KASTO®

Betriebsanleitung
Operating Instructions

BBS560/1060U

6 3 0 1 1 0 6 0 1 3

USA

as from machine-no. 106 006 6301
also valid for cutting length 6100

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KASTO HIGH-PERFORMANCE BANDSAWING MACHINE BBS 560/1060

We congratulate you for having purchased the new KASTO Sawing Machine BBS 560/1060.

KASTO is well known for its high-quality products. Basis for the KASTO quality are the decades of experience in the field of metal cutting and the consistent realization of innovative technologies. Today, KASTO is leading worldwide with regard to integrated storage- and sawing centres.

The many years of experience and the persistent research work, combined with thousends of test cuts contributed to the development and design of the new BBS 560/1060.

The specific features of this machine are:

- quiet running, remarkable damping properties, optimum performance and high sawband life resulting from an outstanding rigidity of the saw unit

- different table lengths allow an optimum adaptation to space and specific customer's needs,

- special pits are not necessary for installation. Thus the machine can be mounted and shifted without extensive preparation work.

- a minimum of space is required because the saw unit is travelling along the table and not vice versa.

These characteristics contribute to making the BBS 560/1060 an ideal sawing machine for large material cross sections.

The ergonomic control panel allows an easy operation and rapid set-up of the machine.

This is a machine, however, that requires careful handling to prevent injuries and to achieve optimum cutting results.

It is of utmost importance to read the Operating Instructions thoroughly, before you start working with the machine.

New personnel needs to be trained specifically, to get familiarized with the machine.

Read the Operating Instructions thoroughly, before you work with it for the first time. Thus you will get to know potentially hazardous locations and movements of the sawing machine and you can avoid damages resulting from operation faults. In addition, you will be rewarded by optimum cutting results.

Always bear in mind that no machine tool is completely without any hazardous locations or -sources

It is essential, therefore, always to observe the general rules on safety and particularly the regulations given in the Chapter **SAFETY PRECAUTIONS WHICH MUST STRICTLY BE OBSERVED** in the preface of this Manual.

Maintenance works should be performed regularly and with care to guarantee smooth running of the machine for a long period of time.

Always keep the Operating Instructions near the machine to have it at hand all the time. Sometimes it is sufficient just to have a look in the **Failure Checklist** to solve minor problems.

Basically, the Documentation for your machine consists of four parts:

Part A: Instructions how to operate the machine
Part B: Instructions concerning transport, installation and maintenance of the machine, hydraulic- und pneumatic plans
Part C: Spare parts drawings and -lists
Part D: Electrical documentation (wiring diagrams, electrical parts lists etc.).

Read Part A thoroughly, if you are not yet familiar with the machine.

Pay particular attention - and observe the **Safety Precautions.**

The "**Glossary**" contains definitions and explanations of specific technical terms from the sawing technology, which may not be familiar to everyone. (E.g. "What actually is the <Width of a cut>? What is understood by <Tooth pitch>)?

Part B contains the Transport Drawing, Installation Drawing and the Maintenance Surveys including a Lubrication Chart as a completion to the chapter **MAINTENANCE** in the Operating Instructions. You will also find the hydraulic- and pneumatic layouts and -lists in Part B.

Part C contains the Spare Parts Drawings and the corresponding lists and Part E the Wiring Diagrams and the Electrical Parts Lists.

Always indicate the machine number and the order number of the needed spare parts if you order any spare parts.

By the way - we appreciate any suggestion that may contribute to improve our Operating Instructions. So, please tell us if you think that certain text descriptions should be more detailed.

Please write to the following address:

KASTO - Maschinenbau GmbH & Co. KG
- Dokumentation -
Postfach 1460

77845 Achern-Gamshurst
Germany

We thank you very much for your efforts and wish you a lot of success with your new machine from **KASTO.**

With kind regards

Your

KASTO - Documentation Department

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SAFETY PRECAUTIONS WHICH MUST STRICTLY BE OBSERVED

This sawing machine has been designed and manufactured in accordance with the latest technical standard on safety regulations. Naturally, such a machine tool has a few potentially hazardous locations and -sources.

We want to ask you, for this reason, to observe the general rules and -regulations on safety precautions and particularly those, given below.

* Please pay particular attention to the following symbols:



WARNING! Disregard or insufficient safety precautions could lead to severe injuries.



ATTENTION! Disregard could result in damage to the machine or AN operation fault.

* This sawing machine has been designed for the cutting of metals.

  It shall be used according to its destined purpose only.

* Read the Operating Instructions thoroughly:

  - to be able to recognize- and to protect yourself from hazardous locations and areas

  - to avoid wrong operations

* Maintenance works must be performed regularly and with care.

* Immediately push the **<EMERGENCY-OFF>** button in the case of an emergency or when any fault occurs. The machine will be switched off completely in this case

* If the machine had been stopped because of an emergency or fault, it must be switched off and the source for the fault must be eliminated before the machine is set into operation again.

* Start-up of the machine shall be performed by qualified personnel only.

* The machine shall be operated by trained personnel only.

* Do not remove any protective guards or -covers during operation.

* Do not operate the machine with long hair or loose clothing. These might be caught by machine parts.

* Works on the electric system shall be performed by qualified electricians only.

* Never approach the sawband while it is running.

* Keep away from any parts while they are in motion (e.g. vices, roller tracks etc).

* Always wear eye protection and protective gloves and also protect your ears when working with the machine.

* Always watch the moving parts while operating the machine (e.g. sawband, vices, roller tracks etc).

* Appropriate material supports must be provided on the infeed- and on the outfeed side of the machine (eg. roller tracks) to prevent the workpiece and the cut pieces from falling down.

  This is particularly important in the case of AUTOMATC machines when using multiple feed (the piese that has been conveyed several times could pitch down on the outfeed side).

* Protective gloves and a suitable eye protection must be worn while changing the sawband.

* Switch off the machine and secure it by means of a locking device at the main switch before performing any maintenance work.

* Switch off the machine and secure it by means of a locking device at the main switch before disassembling any protective guards or - covers.

* Often the material has sharp edges that can cause severe injuries. Handle materials with care and wear working gloves where possible.

* Some alloys, such as magnesium alloys, require special coolants because of their easy inflammability. Please ask your local supplier to use the right coolant for such cases.

* Coolants may contain additives that are hazardous to your health.

  It is essential, therefore, to handle- and dispose of the lubricants and the coolant as stated on the cans and the material data sheets.

* Do not step on the roller rails.

* Do not look into the laser lamp while it is switched on.

* Do not enter the tables while any cuts are carried out.

* There is a high danger of slipping on the tables due to the milled table surface and the use of coolant.

1 TRANSPORT AND INSTALLATION

1.1 TRANSPORT

* The machine is delivered in 8 sub-assemblies.

* The saw unit (I/8)[1] and rail II are provided with a specific transportation hook.

* For all other parts use appropriate points for transportation.

* Also refer to the transport instructions that are attached to the various machine parts.



WARNING!

Only transport the various parts of the machine while using the appropriate locations.

Make sure to use transport means that are strong enough to be able to carry the machine without any problems.

1.2 FLOOR CARRYING CAPACITY



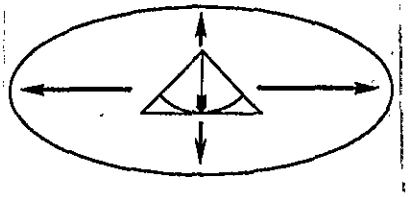
WARNING!

Check whether the shop floor has the required carrying capacity before you install the machine.
Required minimum carrying capacity: machine weight + maximum material weight.

* If necessary, prepare the foundation according to Foundation Drawing in Part B.

[1] The numbers in brackets refer to the General Drawing I (I/..), EDP-no. 01466747 and General Drawing II (II/..), EDP-no. 01487701

1.3 INSTALLATION OF THE MACHINE



* Remove the transport planks and install the machine as follows:

1. Install the front table (I/1) at the assigned location and put levelling screws on the provided steel plates (10-15 mm/0.4-0.6" thick).

   Align table with a level.

2. Install column II (right) (I/18) and mount it to the table. Align with a level.

3. Set rail II (I/3) on the provided steel plates, mount it and align it.

4. Put the saw unit on both rails and slide it in.

5. Attach column I (left) (I/15) and align it.

6. Mount the rear table (I/2) and align it.

* The machine as a whole should be aligned horizontally (check with level).

  Afterwards it can be fastened with the provided M16 glue anchor.

2 PREPARATION FOR START-UP

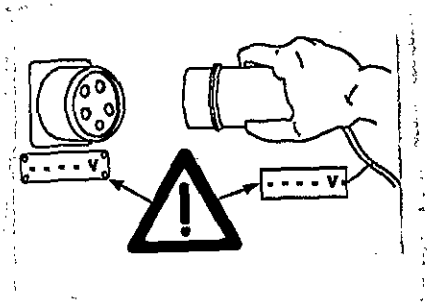
2.1 ELECTRICAL CONNECTION



WARNING!

The mains connection must be performed by an electrician.

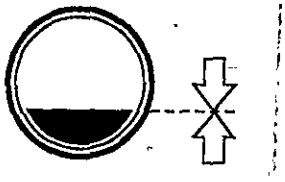
* Electrical connection on main connection (see General Drawing I).
* The stated operating voltage must correspond to the net voltage.
* Total amount of watts: approx. 15.5 kW (20.8 HP).
* The direction of rotation is correct when the sawband is cutting towards the table.
* The direction of rotation can be reversed by changing two phases at the main connector.



2.2 HYDRAULIC SYSTEM

* The hydraulic system is completely filled with oil when leaving our factory and it is operating when the main switch is switched on.
* Check the oil level via the oil sightglass (I/11) regularly.

  For maintenance works refer to item 6.2.



2.3 CONTROL PANEL / FEED AND SPEED CHART

* The **General Drawings I and II** give a comprehensive survey of the various components of your BBS 560/1060 and of the switches and push buttons of the control panel.

FEED AND SPEED CHART

* The Feed and Speed Chart above the control panel contains all important data to ensure correct adjustments of

  - the sawband speed
  - and the feed speed.

* These data, however, represent approximate values.

  Differences in material qualities might occur, for example, which require specific adjustments of sawband feed and -speed.

* Optimum values which correspond to your individual requirements should be determined by various test cuts.

* Adjust the sawband speed according to item 4.5.

* Adjust the feed speed according to item 4.6.

2.4 COOLANT

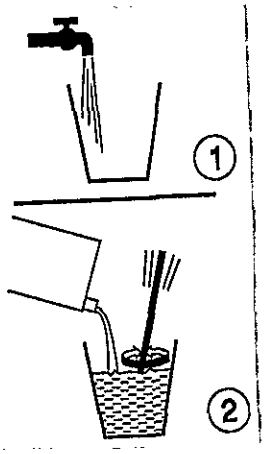


WARNING!

Coolants may contain additives that are hazardous to your health.

It is essential, therefore, to pay attention to the handling- and disposal instructions of the respective supplier.

You will find the relevant details on the containers or the respective data sheets.



* Requiered coolant quantity: see 'Technical Data', item 8.1.

* When mixing the emulsion always stir the concentrate into the water and not vice versa.

  Recommended mixing ratio: approx. 1:5 - 1:10.

* The coolant pump is working as soon as the sawband is switched on.

* After switching on the main switch the coolant supply is adjusted with the switch (II/23) as follows:

  - Position **0**: coolant supply is **OFF**.

  - Position **I**: Coolant supply only while the sawband is running.

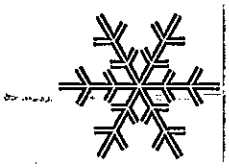
  - Position **II**: Permanent coolant supply (also when the saw motor is switched off).



ATTENTION!

Coolants have a decisive influence on the cutting performance of your machine.

It is essential, therefore, to follow these instructions thoroughly.



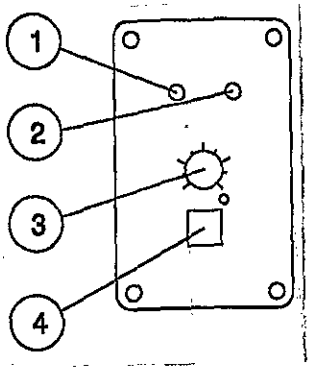
Make sure that the band guides are always sufficiently lubricated by the coolant.

Add commercial anti-freeze in the case of frost.

2.4.1 COOLANT-FLOW CONTROL DEVICE (Option)

Technical data:

- Power consumption: 1,5 W max.
- Protection mode: IP 65, insulated
- Temperature range: -25°C to +80°C
- Mounting position: as required, by means of a universal holder
- Retrofitting is possible



Functions:

1. FAULT
2. OPERATING
3. Quantity adjustment
4. Bypassing the relay

* The coolant controller continuously monitores the quantity of coolant supply. The machine shuts off through a relay when the quantity falls below the preselected minimum quantity.

Adjusting the minimum supply quantity

* Minimum supply quantity: 1.5 l (0.4 US gal).

* Adjust the value by means of the rotary head (3).
  - the green LED (2) indicates that the device is "OPERATING"
  - the red LED (1) indicates "FAULT"



ATTENTION!

Only use the coolant controller when the pump is provided with a strainer.

Cleaning

* Remove the cover at the back of the device and clean by means of a clean piece of cloth.



ATTENTION!

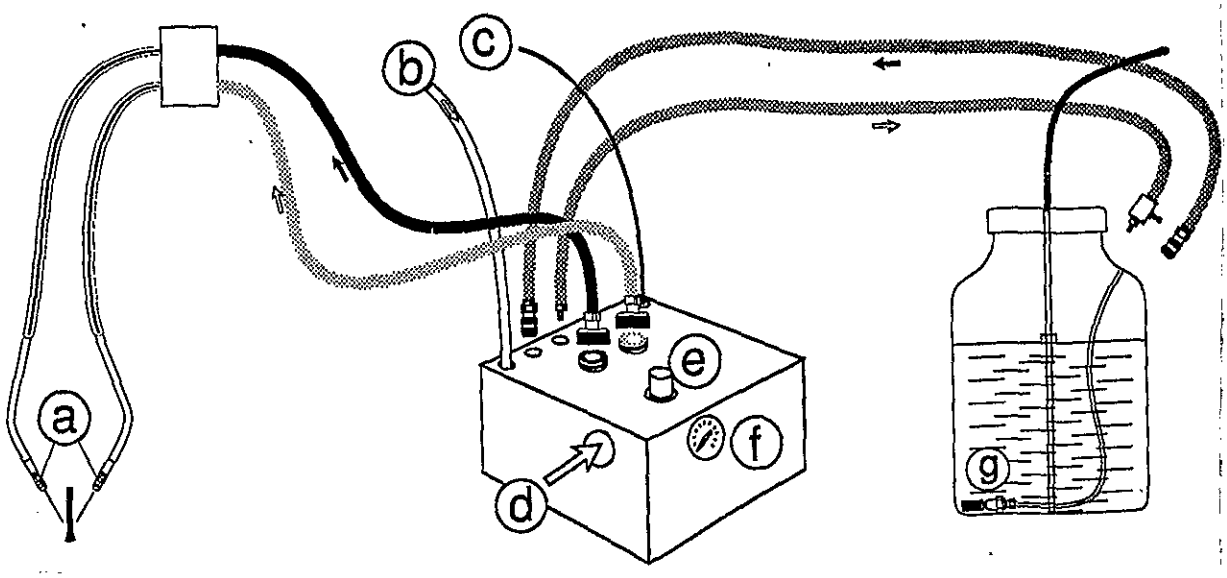
Remove the cover carefully. The axis with bearing bushing for the vane wheel is fitted loosely in the housing and could fall out when the cover is being removed.

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2.4.2 FLUIDAX - Spray Cooling Device (Option)

General Drawing



a) Nozzles
b) Compr. air to device
c) Electrical connection
d) Drain condensed water
e) Pressure controller
f) Manometer
g) Suction filter/Check valve

TECHNICAL DATA

- Voltage: 220 V, AC
- Pressure Controller:
  Display 0-4 bar
  max. pressure 10 bar
- Container: Capacity 25 liters
  Pressurization 0,3 bar,

ATTENTION !

The spray cooling device is intended for cutting speeds up to max. 100 m/min (328 feet/min).

Reduce the cutting speed for a certain period of time after mounting a new sawband until the surface of the sawband is sufficiently smoothed.

Mounting

* The spray cooling device should be mounted by one of our experienced service men.

* If you want to mount the device yourself proceed as follows:

1. Attach- or install the device at a safe place at the machine .

2. Turn the pressure controller (e) counterclockwise until stop (Manometer (f) shows 0).

3. Connect the compressed air (b) at your compressed air supply.

Max. admissible pressure: 10 bar.



ATTENTION!

The supplied air must be absolutely clean, otherwise malfunctions will occur.

If oil-laden air is used, an efficient oil retainer must be provided.

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4. Connect the mains (c). Pay attention that operating voltage of the device and net voltage are identical.

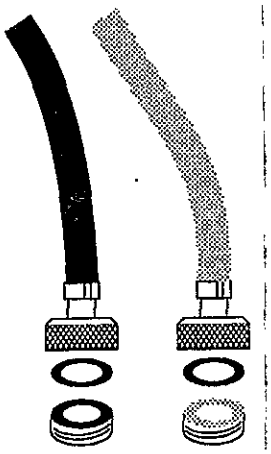


WARNING!

The electrical connection must be performed by a qualified electrician.

---

5. Lay and connect all pipes and cables.





ATTENTION!

Tighten the union nuts with your hand only and do not tighten them too strong:

Black pipe = black connection
White pipe = white connection

The device will only work properly if all the O-rings are fitted correctly.

6. Screw the nozzles on.

   - Adjust the nozzle to ensure that the spray jet reaches the sawband- and the edges of the teeth well and that the coolant also can enter into the spaces between the teeth.

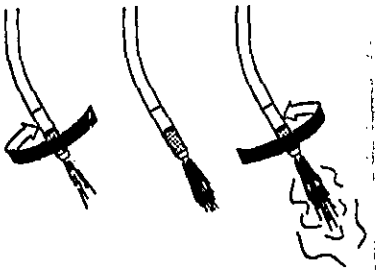
   - Screw the union nuts on afterwards.

7. Turn off the nozzles completely now.

8. Adjust the pressure controller (e) to approx. 0,4-0,5 bar and then open the spray nozzzles again by half a turn.

   It takes a few seconds until the spraying function starts.

9. Fine-adjust the spray jet with the nozzle and correct the pressure through the pressure controller (+/-).



* Adjust the nozzles and the spraying pressure thoroughly in order to make optimum use of the coolant.

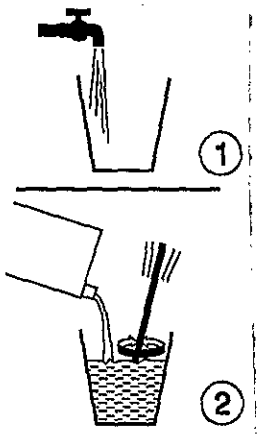
If a nozzle is sputtering:

- **spraying pressure is too low**
- open the nozzle a little more.

If smoke forms during the spraying:

- spraying pressure is too high
- turn off the nozzle a little.

Preparing the coolant for the spray cooling device



* The spray cooling device will only work efficiently if the coolant has been prepared properly.

* It is essential, to pay attention to the following instructions:

1. Stir the coolant emulsion in a clean, separate container (do not use the container of the spray cooling device.

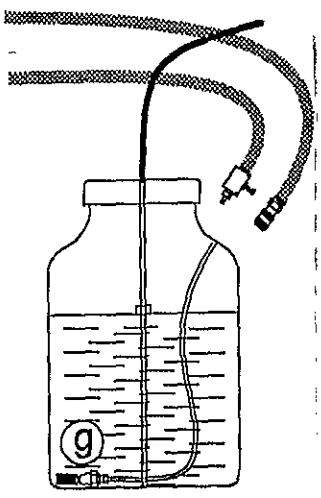
   Mixing ratio: 1:5 - 1:10.

2. Fill-in the water first and then add the coolant concentrate while continuously stirring.

3. Stir the mixture well.

4. Fill the prepared mixture into the container of the spray cooling device.

   Required quantity: approx. 25 l (6.6 US - gal.)



* Apply **utmost cleanliness** when preparing the coolant.

* If you fill the coolant container only partly:

- make sure that suction filter and check valve (g) are completely covered by the liquid.

MAINTENANCE

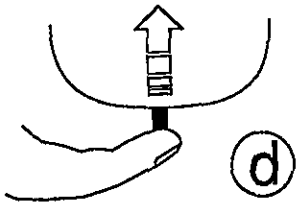
ATTENTION!

Always remove parts like the nozzles, pipes etc. under pressure *in order to avoid* that any liquid enters into the pipes.

If this happens, the nozzles and pipes must *be blown through* with a blowgun.

* Always make sure to keep the complete system clean.
* Clean the container each time you refill it.
* Do not use any aggressive substances.
* Maintenance works that must be performed weekly:
  - Press the button (d) at the maintenance unit to drain the condensed water.
  - Disconnect the coolant container.

    Turn the pressure controller up to max. 4 bar and blow the pipes through for approx. 1-2 minutes.
  - Remove the nozzles and clean them with compressed air.



Check the following parts if the spray cooling device does not work properly:

* - **O-rings** - Check all O-rings.

- **Couplings** - Check all couplings on tightness.

- **Cables** - Check whether the cables are not bent or crushed.

- **Coolant container** - Clean the container and blow the suction filter at the check valve through with a blowgun.

- **Pipes** - Check whether all pipes are tight.

- **Nozzles** - Are the openings free? Use a thin wire of max. ϕ 0.5 mm (0.02") to pierce the nozzle through.

- **Union nuts** - The union nuts should be tightened by hand but not too strong.

- **Solenoid valve** - Pulse reactions must be clearly audible.

- **Pressure controller** - Does the manometer indicate the correct pressure? When you change the pressure controller - is there any reaction at the manometer, too?

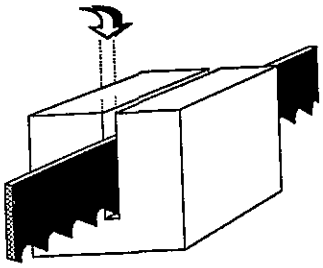
- **Compressed air supply** - Is the supplied air clean? (Do not use air that contains oil)
  Make sure that the pressure has a minimum of 5 bar.

- **Compressed air comes into the coolant container** - Nozzles are choked.

- **Coolant is in the air pipes** - AIR-/COOLANT pipes are not tight. O-rings are not fitted properly or are missing.

3 SAWBANDS

3.1 DIMENSIONS



* Sawband size:

  6960 x 67 x 1,6 mm
  (274" x 2.63" x 0.06")

  or:

  6960 x 50 x 1,6 mm
  (274" x 1.96" x 0.06")

  Bi-metal sawbands are recommended.

* Kerf approx.: 2.4 mm (0.09").

  The kerf of the sawbands may vary slightly due to production tolerances.

3.2 SAWBAND QUALITY

* Best cutting results are achieved using Super-Bimetal sawbands (M42 or M51). This quality can be used for

  - normal carbon steels
  - high-alloy tool steels
  - and stainless steels.

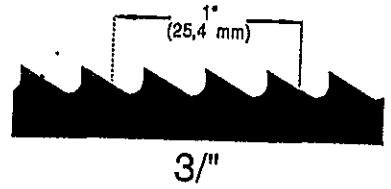
* Carbide-tipped sawbands are available for cutting extremely hard materials.

* The efficiency of KASTO - Sawing Machines is limited by the quality of the sawbands used.

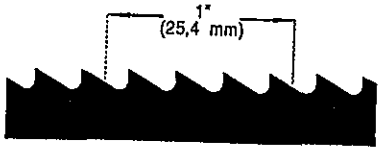
* In order to fully exploit the machine capacity, only use sawbands of a high quality.

* You will receive sawbands of a very high standard from our stores.

3.3 TOOTH PITCH



3/"



4/"

* For the cutting of single workpieces with large cross sections and difficult-to-cut materials you should use sawbands of

  - 1.25 to 2 tpi (conventional pitch)

    (tpi = teeth per inch)

* For the cutting of workpieces of smaller cross sections sawbands of

  - 3 or 2/3 tpi (variable pitch) . can be used.

3.4 BREAKING-IN NEW SAWBANDS



ATTENTION!

The correct breaking-in of a sawband increases its service life considerably.

* We recommend you to break-in new sawbands as follows:

  - Reduce the feed speed by 1/3.

  - Reduce the sawband speed by 1/4.

* These reduced values should be maintained until the sawband has been cutting into the workpiece with its entire width.

* Then increase the sawband speed first and adapt the feed speed afterwards.

3.5 SAWBAND INSTALLATION







WARNING!

Always wear eye protection and protective gloves when you handle sawbands!

* The following steps are to be carried out in succession when a sawband change becomes necessary:

1. Return the saw unit to start-position.
2. Move the feeler of the Band Deviation Control away from the sawband by means of the pin.
3. Open the protective door with platform via stargrip (I/9) and move the door to the side.

   Secure it with a chain against closing.
4. Insert steps (grates) for access to the sawband.
5. Unclamp the chip removal brush with the lever arm and move it away from the sawband (check, if chip removal brush is worn).
6. Relieve hydraulic band tension with the band tensioning lever.
7. Take the sawband from the wheels and slide it out of the sawband guides. Then move it between rear table and saw unit towards the two sets of table clamping (I/13,14).
8. Open inner table clamp (I/14) with 30-wrench and slide the sawband through.

9. Close inner table clamp and...

10. ... then open the outer table clamp (I/13) and remove the sawband.

* Insert the new sawband vice versa.

* Make sure that the teeth point towards the table, before you insert the sawband through the table clamps.

* Clean sawband guides before installing the new sawband.
  Make sure that the sawband back runs against the back-guide bearings.

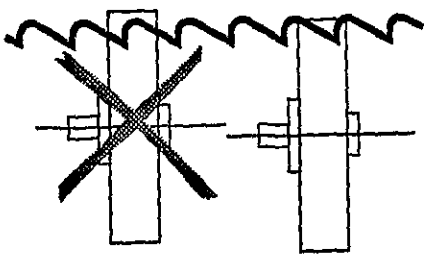
* After sliding the sawband between the sawband guides:

1. Clamp the sawband with a short movement of the band tensioning lever between the sawband guides.

2. Put sawband onto wheels so that sawband touches the shoulder of the wheels (teeth are pointing towards the table).

3. Pretension with the band tensioning lever to such an extent that sawband can be aligned to the correct position.

4. Tension the sawband completely with the band tensioning lever.



5. Move the chip removal brush into cleaning position and fasten with lever arm. Make sure that the tips of the brush run free through the bottom of the teeth (otherwise the brush will be worn prematurely).

6. Remove the steps.

7. Close the protective door with control platform and make sure to lock stargrips firmly.

   The sawband drive will remain blocked, if the protective door is not closed properly.

8. Move the feeler of the band deviation control back to measuring position with the pin.



ATTENTION!

Pay attention to the following instructions if the sawband width changes.

* Sawband tension and sawband guides must be adapted to the corresponding sawband width used (67 mm/50 mm, 2.63"/1.96").

  If the width of the new sawband to be installed is different from the one that had been used before, then the sawband tension and the sawband guides need to be changed accordingly.

* Adjusting the sawband tension: see item 3.6

* Adaptation of the sawband guides at the band guide arms:

  1. Unscrew M12 Allen screws (I/17) of the detachable and the fixed part of the sawband guides.

  2. Lift away detachable parts of sawband guides.

  3. Turn sawband back-guide bearings by 180° until roll pin snaps into bore hole

     - front bore hole = 50 mm (1.96")
     - rear bore hole = 67 mm (2.63")

  4. Fix detachable parts of guides.

  5. Tighten both M12 Allen screws.

3.6 SAWBAND TENSION

* A sawband tensioning of 60 bar is required for sawband size 6960 x 67 x 1.6 mm (274" x 2.63" x 0.06") and of 50 bar for sawband size 6960 x 50 x 1.6 mm (274" x 1.96" x 0.06").

* Adjust with pressure reducing valve (I/20) and check at ammeter (I/19).

4 PREPARING THE MACHINE FOR A CUT

4.1 ALIGNING THE WORKPIECE



WARNING!

There is a high danger of slipping on the tables due to the milled table surface and the use of coolant.

* The workpiece can be aligned when it is loaded on the table with a crane.

* The task of aligning the workpiece will be considerably facilitated by using hydraulic roller rails (I/22) and a laser lamp (I/7) (options, refer to items 5.1 and 5.2).

* The cut-off width can be easily adjusted with a manually adjustable measuring stop (I/23) (option, refer to item 5.5).

4.2 CLAMPING THE WORKPIECE

* Small blocks or workpieces can be clamped onto the table with jaws (option, refer to item 5.6) or by means of electromechanical clamping magnets (option refer to item 5.7).

* Clamping is not necessary when heavy blocks are cut.

4.3 RAPID "FORWARD/RETURN" OF THE SAW UNIT

* Press push buttons "RAPID (II/17) and FORWARD" (II/16) to approach the saw unit close to the front of the workpiece.

* Make sure to stop the saw unit before the sawband touches the workpiece in order to avoid any sawband damage.

4.4 ADJUSTING THE MOVABLE BAND GUIDE ARM

* The movable band guide arm can be lifted or lowered with the push buttons (II/24).

* The band guide arm should always be adjusted approx. 20 mm (0.8") above workpiece height.

4.5 ADJUSTING THE SAWBAND SPEED

* Adjust the sawband speed with the push buttons (II/11, 12).



ATTENTION!

Adjust the sawband speed only while the saw motor is running.

* Have a look in the Feed- and Speed Chart to see which speed is recommended.

  The sawband speed depends on

  - the material quality
  - the height of the workpiece

* The speed range is infinitely variable from 14 - 75 m/min (46' - 246'/min).

* The sawband speed can be read via LED display (II/9).

4.6 ADJUSTING THE FEED SPEED

* Adjust the feed speed with the rotary knob (II/15).

* Have a look in the Feed- and Speed Chart to see which feed speed is recommended.

  The feed speed depends on

  - the material quality
  - the height of the workpiece



ATTENTION

Two feed speed ranges - I and II can be adjusted with the selector switch (II/14):

Please pay attention to the following instructions if you want to switch from I to II.

Position I: = 0.7 - 27 mm/min
(0.03"- 1.1"/min)
Position II: = 0.7 - appr. 270 mm/min
(0.03"-10.6"/min)

* Do not switch from pos. I to pos. II while a cut is performed.

  The feed speed would suddenly be increased tenfold and the sawband could be damaged.

* If you wish to increase cutting feed and need to switch over to position II (0.7 - 270 mm/min) during the cut please proceed as follows:

  1. Reduce the cutting feed (II/15) to "0".

  2. Turn selector switch (II/14) to position II.

  3. Readjust cutting feed (II/15) (make sure that cutting feed- and speed are in line with data on Feed and Speed Chart).

* When breaking-in new sawbands see item 3.4.

4.7 ADJUSTING THE CUTTING DEPTH

* Adjust the cutting depth as follows:

1. Switch on the counter (II/7)

2. Preselect the cutting depth by means of the buttons on the counter (II/5)

3. Press the 'C'-button as soon as the sawband begins to cut into the material (e.g. by ear).

   - When the 'C'-button is pressed the preselected required value is read into the LED-display.

     The counter counts back to 'zero' and the machine stops automatically.

   - The LED-display always shows you the distance that still needs to be cut (control function).

   - The sawband is cleared from the material by a few mm when it is stopped during the cut.

   - The LED-display is automatically corrected so that you can continue cutting without a new adjustment.

* If the counter is not activated the saw unit will stop at the end of the table.

4.8 KASTO BAND-DEVIATION CONTROL-BC

* The KASTO-Band Deviation Control closely surveys the sawband during cutting operation.

* As soon as a certain deviation limit is approached a control lamp is illuminated or the machine is switched off altogether.

* Straight cuts and precise cutting lengths are thus obtained applying the KASTO-Band Deviation Control.

SWITCHING ON THE DEVICE

* The KASTO BC is switched on via switch "Band Control ON/OFF".

* When lamp LED 2 is illuminated the values on band deviation and material width can be adjusted (Fig.1).

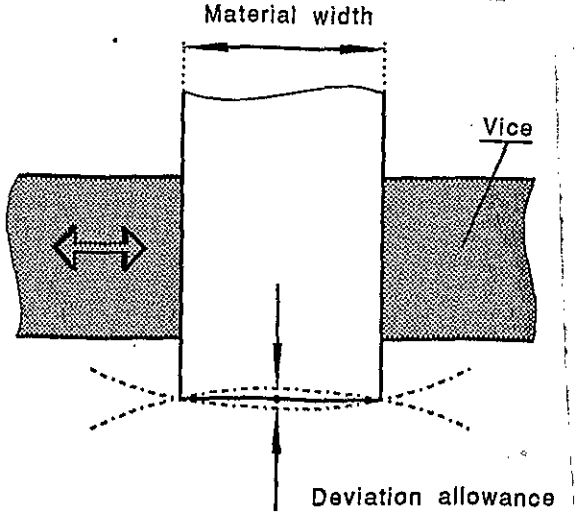


Fig.1: Band Deviation and Material Width

ADJUSTING THE ALLOWED DEVIATION

* The range of the allowed deviation is adjusted (in mm) on the left indicating disk (Fig. 2).

* The BC automatically checks whether this preselected range of deviation is in accordance with the machine-specific values.

* If this is not the case lamp 4 will be illuminated and the saw cannot be started.

* An adjusting error can be corrected by reducing the value - lamp 4 will go out.

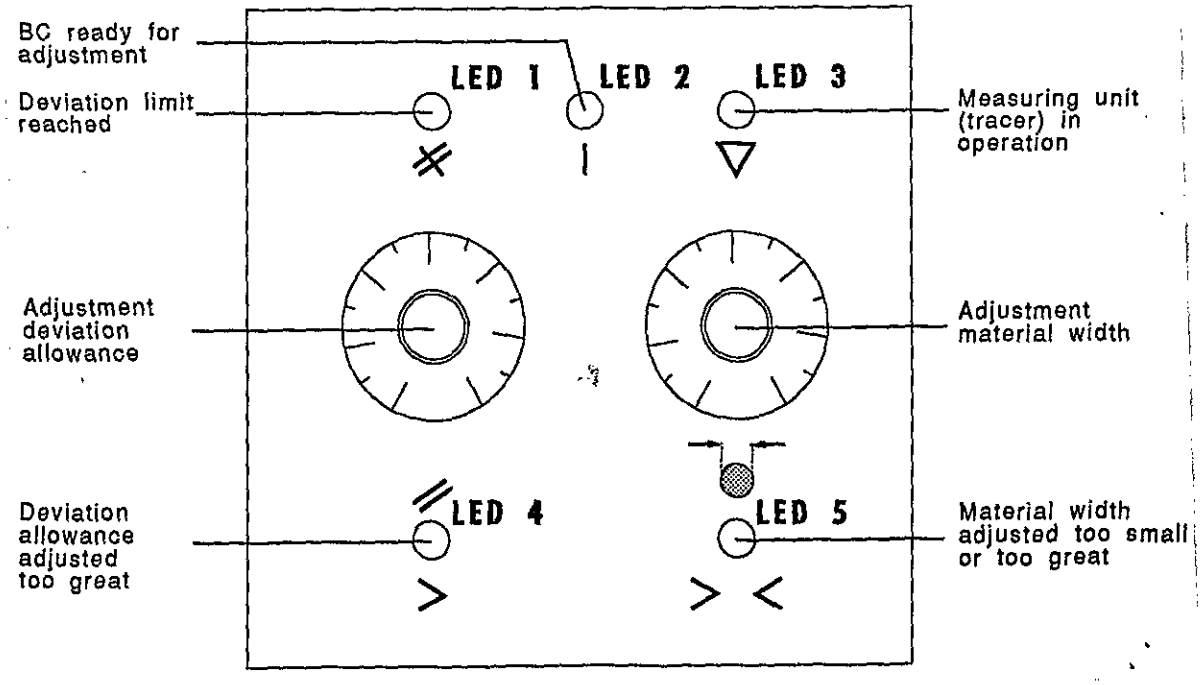


Fig. 2: Control Panel BC

ADJUSTING THE MATERIAL WIDTH

* The material width is adjusted (in mm) on the right indicating disk (Fig.2).

* The BC automatically checks if this preselected value is in accordance with the cutting capacity of each individual machine (see "Technical Data" of the operating manual).

* Lamp LED 5 will be illuminated, if this is not the case - the saw cannot be started.

* An adjusting error can be corrected by reducing the value or by increasing it, respectively - lamp 5 will go out.

MODE OF OPERATION

* Approx. 3 sec. after switching on, the KASTO BC memorizes the preselected deviation value as zero point and lamp LED 3 will be illuminated.

* The BC is now in operation and carries out 10 measurements per sec. whose average values are compared to the preselected deviation value.

* As soon as the band deviation comes close to about 70 % of the deviation limit lamp LED 1 will be illuminated.

* The deviation can possibly be reduced by lowering the feed speed.

* If the feed speed now is well below the value recommended in the "Feed and Speed Chart" an exchange of the sawband seems necessary.

* When the band deviation comes close to 100 % of the deviation limit the machine shuts off and lamp 1 will be illuminated. In this case the sawband needs to be exchanged.

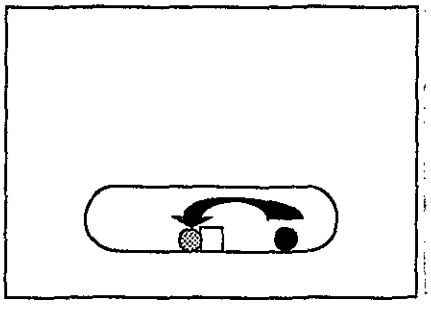
SAWBAND INSTALLATION

ATTENTION!

In order to avoid damaging the feeler during sawband exchange, the unit must be moved away from the sawband.

* The feeler is moved away by means of a pin which is unlocked (see Fig. 3, below).

* After sawband installation the feeler is returned to measuring position by means of this device.



(Fig. 3)

MAINTENANCE

* The measuring unit should occasionally be checked on smooth running.

* The commplete measuring unit must be cleaned regularly from chips and coolant residues. Protect measuring unit from shock.

4.9 STARTING A CUT

* Start the machine as follows:

1. Load the material, align and clamp it, if necessary.
2. Move the saw unit close to the workpiece with rapid speed (item 4.3).
3. Adjust the movable band guide arm (item 4.4).
4. Adjust the cutting depth (item 4.7).
5. Activate the band deviation control (item 4.8).
6. Adjust the cutting feed (item 4.6).
7. Adjust the coolant (II/23).
7. Start the cut by pressing the push button **Sawband ON (II/18)**.



WARNING!

Never approach the running sawband!

High danger of severe injuries!

9. Adjust the sawband speed (item 4.5) while sawband is running.



WARNING!

Do not enter the tables while any cuts are carried out.

Narrow cut pieces must be supported accordingly to prevent them from falling over after being cut through.

4.10 SHUT-OFF DURING THE CUT

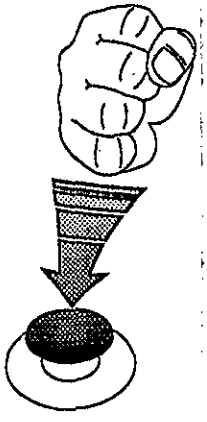
* The saw unit can be removed from the workpiece with the sawband still running when push button saw "RETURN" (II/20) and inching button (II/22) are simultaneously pressed.

  The teeth will not be damaged this way.

4.11 FAULT INDICATION

* The machine shuts off automatically when a main motor overload is released.
* In this case the fault indication light (II/21) is constantly illuminated.
* The machine will also shut off when a sawband breaks and when the coolant supply is not sufficient.

4.12 EMERGENCY-OFF





WARNING!

Immediately push the <EMERGENCY-OFF> button (II/36) in the case of an emergency or when any fault occurs. The machine will be switched off completely in this case.

If the machine had been stopped because of an emergency or fault, it must be switched off and the source for the fault must be eliminated before the machine is set into operation again.

* Turn the red head to switch the machine on again.

4.13 CHIP REMOVAL

* The chip conveyor also serves as the coolant container.

  Connection via the socket at the machine base.

5 OPTIONS

5.1 LASER LAMP



WARNING !

Do not look into the laser lamp while it is switched on.

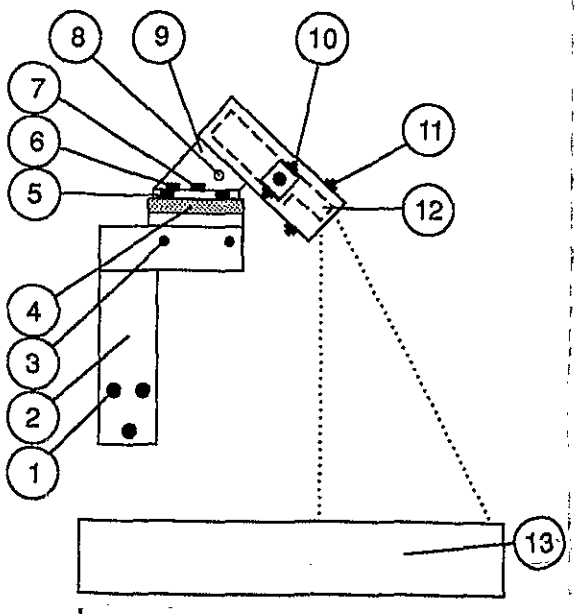
* Switch on the laser lamp (II/37) to project the cutting line onto the workpiece and align the workpiece accordingly.

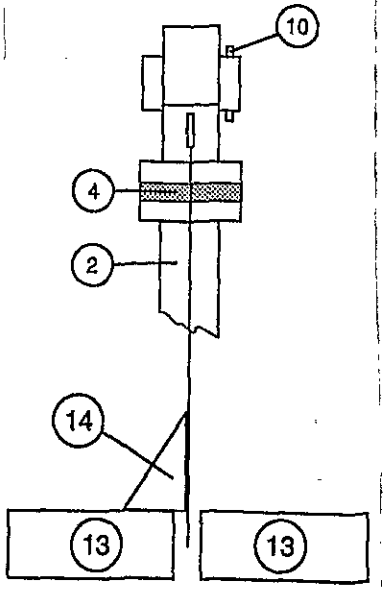


ATTENTION!

Wait approx. 30 sec. between switching off the laser lamp and switching it on again.

How to Adjust the Laser Lamp





* If the laser lamp needs to be readjusted (eg: when it had been hit by a crane hook or similar thing), please proceed as follows:

1. Align the support (2) of the laser lamp with a spirit level parallel to the table (13) by means of the set screws (1).

2. Mount the intermediate plate (4) together with the holder (9) of the laser lamp on the support and fasten it with the Allen screws (5,6,7).

   Fasten the screws only to such an extent that the laser holder (9) can still be turned and shifted.

3. Adjust the laser beam according to the cutting length by means of the set screws (11).

4. Use a square (14) and adjust the laser beam by means of the set screw (10) rectangular to the table (13).

5. Align the laser beam parallel to the cutting line by means of the aligning screws (8) and fasten the fixing screw (6).

6. Carry out a test cut and adjust the laser beam with the set screws (3) [4 screws] so that the beam is exactly in the cutting line.

7. Check again that the laser beam is rectangular to the table (13) and correct it, if necessary (see item 4.).

8. Repeat item 3, if required.

5.2 ROLLER RAILS FOR ALIGNING THE MATERIAL



WARNING !

Do not step onto the roller rails.

There is a danger of slipping.

* The roller rails can be moved easily and quickly from one table interval to another as follows:

  - Remove the chain of the protective rail

  - Unscrew the Allen screw underneath the table by which the roller rail is fastened at the table

  - Pull up the yellow bars for transport.

* The workpiece to be aligned must always be carried by two roller rails at a time.

* The weight of the workpiece must not exceed the carrying capacity of the roller rails. Carrying capacity per rail: 7.5 tons (16.535 lbs).

  An excess-load safety-device is provided.

* The rollers are operated from a portable control panel.

* Each rail can be lifted separately approx. 50 mm (1.9") above table height.

* The rollers of each rail are separately driven.

5.3 ELECTROMECHANICAL MEASURING STOP (WITH LONG STOP RAIL) (I/24)

* Move the measuring stop per push button roughly to the required position and fine-adjust via handwheel.

* Display on digital positioning read-out.

* The maximum cutting width is reduced to 860 mm (33.8") when this measuring stop is used (please refer to Foundation Drawing)



ATTENTION!

The workpiece cannot be aligned by means of the measuring stop. It only serves as a stop for the workpiece to be cut.

5.4 ELECTROMECHANICAL MEASURING STOP

* The max. measuring range is 0 - 1000 mm (0 - 39.3").

  Range I: appr. 0-500 mm (0-19.6")

  Range II:appr. 500-1000 mm (19.6"-39.3")

* Move the stop rail manually to the respective range and fasten it with the M 16 Allen screws.

* The datum dimensions need to be set anew each time the stop rail is moved from one range to another.

* Proceed as follows:

  1. Set switch S 109 in the control cabinet to position I.

  2. Adjust the respective datum dimension for range I or II (please refer to test record) by means of the inching buttons.

  3. Move the stop rail by push buttons (II/39, 40) (' + ' direction) against stop.

  4. Move the stop rail by push buttons (II/40, 41) (' - ' direction) away from the stop - the datum dimension is set now.

  5. Set switch S 109 in the control cabinet to position '0' again.

* The required cut-off length is adjusted by push buttons (II/39, 40, 41).

  The position is indicated on the LED-display.

5.5 MANUALLY ADJUSTABLE MEASURING STOP (I/23)

* This measuring stop has a range of 105 mm (4.13") and it is adjusted via handwheel.

  It can be fastened manually to the requested pegs.

  Distance between the pegs: 100 mm (3.93").

* The maximum cutting width is reduced to 900 mm (35.4") by this measuring stop (please, refer to Foundation Drawing).

5.6 CLAMPING JAWS

* The clamping claws are fastened to the table by means of 2 clamping levers.

* The clamping arm can be adjusted vertically via stargrip.

* With a second clamping instrument the workpiece is clamped onto the table.

5.7 ELECTROMECHANICAL CLAMPING MAGNETS

* The type of magnets used are permanent magnets.

  When the magnets are magnetized (duration approx. 5 - 10 sec.) their power remains stable without additional consumption of energy. Thus, energy is only needed during magnetizing - and demagnetizing processes.

* The magnet plates are installed in the intervals of the tables.



ATTENTION!

When mounting the clamping magnets, make sure to lay the cables tightly in the provided holding angles. Otherrwise they might be damaged by the moving saw unit.

* The clamping magnets are operated by twist levers with integrated indicator lights (II/33, 34).

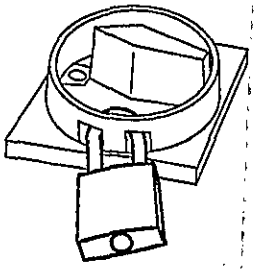
SWITCHING ON (MAGNETIZING)

- Turn the twist lever against 'I' and let go
- The indicator light on the lever is flashing during the magnetizing process (duration approx. 5 - 10 sec.)
- The control light illuminates as soon as the clamping magnets are magnetized.

SWITCHING OFF (DEMAGNETIZING)

- Turn twist lever against '0' and let go
- The indicator light on the lever flashes during the demagnetizing process (duration approx. 5 - 10 sec.)
- The control light goes off

6 MAINTENANCE



WARNING!

Switch off the machine and secure it by means of a locking device at the main switch, before you perform any maintenance work.

6.1 COOLANT CONTAINER / COOLANT

WARNING!

Coolants may contain additives that are hazardous to your health.

It is essential, therefore, to pay attention to the handling- and disposal instructions of the respective supplier.

You will find the relevant instructions on the containers in which the concentrate is supplied and on the accompanying data sheets.

* Check the coolant level regularly.
* Required coolant quantity: depending on the cutting length, see 'Technical data' in Appendix.
* Check the coolant in the container upon correct mixing ratio before refill.
* Recommended mixing ratio: 1:5 - 1:10.

* When mixing the coolant, always stir the concentrate into the water and not vice versa.





ATTENTION

Add commercial anti-freeze in the case of frost.

* Clean the coolant sump and the pump filter regularly (make sure to return the pump properly afterwards).

* Change the coolant completely after some time and clean the coolant tank on this occasion.

  Pour disinfectant into the coolant container approx. 24 hours before changing the coolant in order to extinguish fungi and bacteria.

  Switch on the machine and let the coolant **with the disinfectant** run through the coolant pipes, too.



ATTENTION

If your machine is equipped with a coolant heating (option):

- **If you change the coolant completely, switch off the machine during this period of time otherwise the heater tubes could burn out.**

* KASTO coolant concentrate guarantees high cutting performance and a long band life.

* For special instructions concerning

  - the adjustment of the Spray cooling device (option)

  - the adjustment of the Coolant-flow controller (option)

  refer to item 2.4.1 and 2.4.2



ATTENTION

Coolants have a decisive influence on the cutting performance of your machine.

It is essential, therefore, to follow these instructions thoroughly.

6.2 HYDRAULIC SYSTEM



WARNING!

In case of performing maintenance work at the hydraulic system:

- **Return the saw unit back to the starting position**
- **lower the band guide arm (II/24) or support it by means of an appropriate device**
- **release the band tension, and then relieve the hydraulic pressure, if necessary.**

* Check the oil level regularly (I/11).

  Filling nozzle, see General Drawing (I/10).

* Refill with hydraulic oil HLP 46 (for example, BP Energol, HLP 46).
  For further details refer to the enclosed Lubrication Instructions.



ATTENTION

If your machine is equipped with a hydraulic oil heating (option):

- **If you change the hydraulic oil completely, switch off the machine during this period of time otherwise the heater tubes could burn out.**

6.3 SAWBAND DRIVE

* The gear unit for the sawband runs in oil.

* Check the oil level at the sightglass (I/5) regularly.

* Refill with gear oil of the quality CLP 100 - 140 (for example BP Energol, CLP 100 - 140).

  Filling nozzle (I/6), see General Drawing.

* Grease bearing for drive shaft (lubrication nipple), if necessary.

6.4 SAWBAND GUIDE

* The band guides consist of two side guide plates (I/17).

* One of the plates is fixed and the second is pressed via cylinder against the sawband.

* The sawband is clamped and unclamped between the plates by the band tensioning lever.

  The carbide plates are ground.

* It is essential to clean the band guides before installing a new sawband.

* The back-guide bearings should be changed approx. every 6 months on single shift operation.

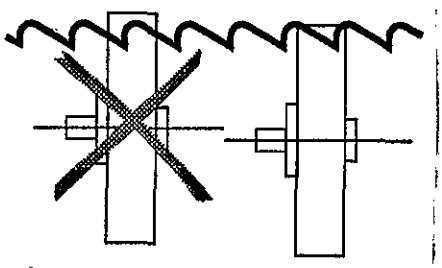
* Plain parts and guides should be cleaned regularly and should be greased slightly.

* The sawband guide needs to be adapted to the width of the sawband used (67 mm/50 mm, 2.63"/1.96").

* If the width of the new sawband to be installed is different from the one that had been used before, the sawband guide needs to be changed accordingly.

  Instructions for changing: see item 3.5.

6.5 CHIP REMOVAL BRUSH



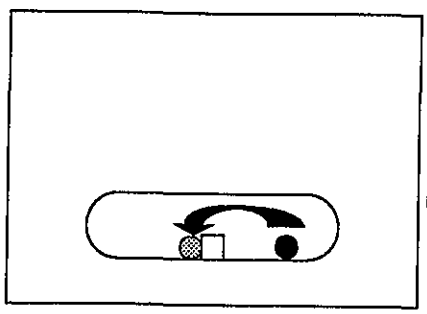
* The chip removal brush with a separate motor drive is fastened at the drive shaft.

* Adjust the brush with the set screw allowing its tips to run free through the bottom of the teeth.

* If it is adjusted too close, the tips will bend which reduces the effectiveness of the brush and causes early wear.

* Check the brush regularly and change it after wear.

6.6 BAND DEVIATION CONTROL



* Move the measuring feeler away from the sawband before you change sawbands.

* Check the measuring feeler regularly on smooth running.

* Clean the complete measuring unit regularly from chips and coolant residues and avoid mechanical damage.



ATTENTION!

Maintain and lubricate the machine

- **regularly and**
- **thoroughly**

to ensure that it will work trouble-free for a long period of time to your full satisfaction.

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6.7 TIME INTERVALS WHEN MAINTENANCE WORKS SHOULD BE PERFORMED.

Daily:

* Check the hydraulic oil level.
* Check the coolant level.
* Check the chip removal brush on wear.

Weekly:

* Clean and lubricate the guides of the band guide arm.
* Clean the band guides and the band back guides (they should generally be cleaned with every sawband change).
* Clean the measuring unit of the Band Deviation Control (it should generally be cleaned with every sawband change).
* Clean the working surface of the band wheels.
* Check the suction basket on contamination.

Quarterly:

* Lubricate the bearings of the band wheels
* Clean and lubricate the chains.
* Check and - if necessary - exchange the carbon brushes of the D.C. motors.
* Check the band guides on wear.
* Clean the filter mat of the control cabinet fan.

Every Year:

* Change the hydraulic oil and the gaer oil.
* Clean or - if necessary - exchange the suction filter
* Check and - if necessary - exchange the seals.
* Check and - if necessary - readjust the pressures.

Every 2 years:

* On the spur-gear drive of the LENZE variable speed unit.
  - drain the grease.
  - clean the gear unit.
  - refill with lubricant as indicated on the nameplate.

If required:

* Check whether the mixing ratio of the old coolant in the container is still correct before you add the new coolant. (Mixing ratio: approx. 1 : 5 to 1 : 10).

  The mixing ratio can be checked by means of a refractometer, for instance.

7 POSSIBLE FAULTS AND THEIR CAUSES/ELIMINATION

FAULT	CAUSE / REMEDY
Machine cannot be switched on:	* Protective cover is not properly closed. * Check the electric cables. * One of the EMERGENCY-OFF buttons has been hit.
Red fault indicator light illuminates	* Check main motor overload in control cabinet (press red button) Possible cause: - sawband break - Chip conveyor is blocked
No coolant supply:	* Check the coolant level (refill, if necessary). * Clean the suction basket and the coolant pump. * Coolant is contaminated by chips and dirt. * Coolant hoses are bent. * Open the coolant valve.

FAULT	CAUSE / REMEDY
Sawband cannot be switched on	* Cutting-depth selection has been activated ('ON') but a value has not been entered. * Band tensioning lever is not in 'OPERATING' position (if it is in the middle position, the machine can be started but the pressure decreases and the machine shuts off). * No coolant supply (coolant flow controller has responded).
Inaccurate cut piece dimensions:	* Pay attention to the width of cut (tooth set).
High-pitched cutting tone:	* Sawband speed and cutting feed are not adjusted correspondingly.
Chip conveyor does not work:	* Chain is jammed. * Material pieces are blocking the chain.
Hydraulic-oil leakage:	* Check fittings, cylinder connections and sealing components on tightness.

FAULT	CAUSE / REMEDY
The sawband is deviating:	* The sawband is worn. * Choose the right sawband (quality, tooth set, tooth pitch etc.) * Check the band guides (they are possibly contaminated, out of place or not properly closed). * Check the sawband back-guide rollers on smooth running. * Material is not aligned properly. * Cutting speed and cutting feed are not in line with the values stated in the Feed- and Speed Chart. * There are differences in the material quality that require individual adjustments of the cutting speed and the cutting feed.
The life of the sawband is not satiscfactory:	* You have chosen a poor sawband quality. * Check the mixing ratio of the coolant (approx. 1:5 - 1:10). * Check the sawband back-guide bearings on smooth running. * Break-in sawbands properly. * The back of the sawband must not run against the shoulder of the wheels. The teeth must protrude entirely over the wheel.

8 APPENDIX

8.1 TECHNICAL DATA

KASTO Block-Bandsawing Machine, BBS 560/1060

sawband width 67 mm (2.63") ..... 60 bar
sawband width 50 mm (1.96") ..... 50 bar

Dimensions of the machine
Length (see data on the following page)
Width approx. (with opened door)... 5010 mm (197.2")
Height approx. (with laser lamp) ... 3080+900 mm
(121.2"+35.4")
Total space required (see data on the following page)
Table height ..... 1340 mm (52.7")
Total weight (see data on the following page)
Total power approx. ..... 15,5 kW (20.78 HP)
Power-saw motor approx. ..... 7,5 kW (10.05 HP)

Cutting height, with
KASTO-Band Control, max. ..... 560 mm (22")
Cutting height, without
KASTO-Band Control, max. ..... 620 mm (24.4")

Cutting width:
- with electromechanical measuring stop
(continuous stop rail) ..... 860 mm (33.8")
- design with short stop rail ..... 1000 mm (39.3")
- with manually adjustable
measuring stop, max., approx. ..... 900 mm (35.4")
- without measuring stop, max. ..... 1060 mm (41.7")

Cutting width, min. ..... 10 mm (0.39")

Cutting speed, infinitely variable . 14 - 75 m/min
(45.9'- 246'/min)
Cutting feed, infinitely variable .. 0.7 - 27 mm/min
(0.03" - 1.1"/min)
and 0.7 - 270 mm/min
(0.03 - 10.6"/min)

Front table load, max. (see data on following page)

Sawband dimensions ..... 6960 x 67 x 1.6 mm
(274.01"x2.63"x0.06")
or 6960 x 50 x 1.6 mm
(274.01"x1.96"x0.06")

Sawband back guide: roller bearing, interchangeable
Sawband guide: carbide, interchangeable, adjustable
Sawband cleaning: by easily interchangeable, motor-driven wire brush
Coolant delivery: via 2 coolant nozzles, coolant required (see data on following page). pump delivery, approx. 100 l/min (26 US-gal./min)

DIMENSIONS AND WEIGHTS OF THE VARIOUS CUTTING LENGTHS (APPROXIMATE VALUES)

Cut.length (mm) (indches)	2000 (78.7")	3000 (118.1")	4000 (157.4")	5000 (196.8")	6000 (236.2")	7000 (275.5")	8000 (314.9")	9000 (354.3)
Total length (mm) (inches)	5040 (212.6")	6040 (261.8")	7040 (301.2")	8040 (340.6")	9040 (380")	10040 (419.3")	11040 (458.7")	12040 (474")
Total weight (kg) (lbs)	10500 (23149)	12000 (26455)	13500 (29762)	15000 (33069)	16500 (36376)	18000 (39683)	19500 (42990)	22000 (48501)
Front table load,max.(kg) (lbs)	16000 (35273)	24000 (52910)	32000 (70547)	40000 (88183)	48000 (105820)	56000 (123456)	64000 (141093)	72000 (15873)
Requ. space-pulling the chip conveyor from under the table(mm) (inches)	9040 (356")	11040 (435")	13040 (514")	15040 (593")	17040 (671")	19040 (750")	21040 (829")	23040 (9071")
Requ. space-lifting the chip conveyor after table disassembly (mm) (inches)	7640 (301")	8640 (341")	9640 (380")	10640 (419")	11640 (459")	12640 (498")	13640 (537")	14640 (5764")
Required coo-lant,ca.(l) (US-gal.)	265 (70)	330 (80)	400 (106)	465 (123)	535 (142)	605 (160)	670 (177)	735 (194)

8.2 DATA ON THE NOISE LEVEL AT THE WORKING PLACE

* The noise level has been measured under normal working conditions at a distance of approx. 1 m (3 ft.) from the machine surface and at a height of approx. 1.6 m (5.3 ft.).

The highest noise level measured is stated below.



WARNING!

Always wear ear mufflers or other appropriate means to protect your hearing. Working near the sawing machine for a longer period of time can cause damages of hearing.



Measurement method:

Continuous noise level measuring.

	BBS 560/1060
Material used	1.2311material ϕ 500 mm
Noise level - dB(A)	
Idle running	72
Middle of workpiece	76

* There are various factors that can influence the noise level:

Each material produces a specific noise level when being cut so that, in the case of some materials, the noise level will be a little higher than indicated above.

Depending on the wall thickness and the type of section, the noise level when cutting sections could also be higher than indicated here.

Higher noise levels will also occur when the technology values change: Cutting speeds or tooth pitches that do not correspond to the recommended values could result in higher noise levels. The same can happen when a worn sawblade is used.

8.3 FEED AND SPEED CHART

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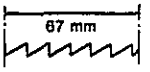
Richtwerttabelle
Feed and speed chart
Tableau de réglage

KASTO-BBS 560/1060

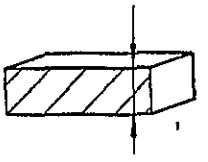
Werkstoff Material Matière	[m/min]	Zähne pro Zoll Teeth per inch dent/pouce		Vorschubeinstellung Feed setting Avance de travail mm/min Werkstückhöhe Epaisseur Height of material									
				50		150		300		450		600	
Cu, Al,	max.	3		130		100		67					
		2	2/3							44			
		1,25										30	
C 45, GG 22 EN 8 XC 45, Ft 22 1.0503	60–70	3		108		46		24					
		2	2/3							16			
		1,25										11	
St 37, 1.0110 St 42, 1.0130 EN 2, A 37, A 42	55–65	3		96		41		21					
		2	2/3							14			
		1,25										10	
C 60, 16 Mn Cr 5 EN 9 EN 207 XC 60, 16 MC 5 1.0601 1.7131	50–60	3		84		35		19					
		2	2/3							12			
		1,25										9	
34 Cr Mo 4, 20 Mn Cr 5 EN 19 B, EN 18 34 CD 4, 20 MC 5 1.7220 1.7147	45–55	3		78		33		17					
		2	2/3							11			
		1,25										8	
42 Cr Mo 4 EN 19 C 42 CD 4 1.7225	40–50	3		72		30		16					
		2	2/3							10			
		1,25										7	
10 Cr Mo 9 10 EN 29 Z 12 CD 5 1.7380	35–45	3		54		23		12					
		2	2/3							8			
		1,25										6	
100 Cr 6, X 5 Cr Ni 18 9 EN 31 ball bearing steel EN 58 E 100 C 6, Z 6 CN 18-9 1.3505, 1.4301	30–40	3		45		19		10					
		2	2/3							7			
		1,25										5	
26 Cr Mo 7, 1.7259 X 5 Cr Ni Mo 18 10, 1.4401 EN 20 B, EN 58 J 26 CD7, Z 6 CND 18-12	25–35	3		39		16		9					
		2	2/3							6			
		1,25										4	
X 40 Cr Mo V 51, 1.2344 X 10 Cr Ni Ti 18 9, 1.4878 Chrome steel, EN 56 Z 40 CDV 5, Z 10 CNT 18-10	20–30	3		33		14		7					
		2	2/3							5			
		1,25										3	
X 210 Cr W 12, 1.2436 X 10 Cr Ni Ti 18 10, 1.6903 Tungsten Chrome Tool Steel, EN 58 E Z 200 CW 12, Z 6 CNDT 18-10	15–25	3	3/4	23		10		5					
		2	2/3							3			
		1,25										2	
Sonderstähle Special steels Aciers spéciaux	min.	3	3/4	14		6		3					
		2	2/3							2			
		1,25										1	



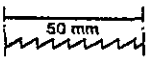
→ 50 bar



→ 60 bar



max 150 mm



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8.4 PROGRAM OF POSSIBLE OPTIONS FOR BBS 560/1060

With the following components the BBS 560/1060 can be usefully extended and completed. The operating personnel will be considerably relieved, preparation and operating cycles will be reduced and the machine can thus be exploited to a maximum.

* Laser lamp to facilitate the aligning of the material.

* Roller rails for aligning the material (in conjunction with a laser lamp.

* Various designs of measuring stops.

* Clamping jaws for clamping the workpiece manually.

* Electromechanical clamping magnets.

8.5 GLOSSARY



What actually means ... ?

ATTENTION!

These are technical terms that cover the whole range of sawing technology. They need not necessarily have to do with your specific machine.

Arc-type cutting principle (Power Hacksaw)

The saw blade performs an arc-type movement during the cut stroke. This means that only a section of the saw blade is used at any given time. The result are high cutting feeds and long tool life

Band guides

Guides, designed as rollers or carbide plates to ensure a stable and straight motion of the blade.

Bandsaw blade

Tool of the bandsawing machine

Breaking-in of a tool

The first cuts with a new cutting tool must be performed at reduced --> CUTTING FEED and --> CUTTING SPEED settings to ensure that the sharpness of the sensitive teeth is not lost upon the first contact with the material. The correct breaking-in of the tool increases its life considerably.

Bandsawing machines: Reduce the --> CUUTTING FEED by one third and the --> CUTTING SPEED by one fourth, as compared to the normal setting, over an area of approx. 300 cm^2. Then gradually increase the --> CUTTING SPEED first and afterwards the --> CUTTING FEED until optimum performance is achieved.

Power hacksaws: reduce the cutting pressure as compared to the normal setting by 1 step. After approx. 3 - 5 cuts the normal settings can be adjusted again.

Bundle cut

Simultaneous cutting of several workpieces that are clamped in several layers on top of each others.

Contour cut

The cutting of shapes from plate-type materials

Conventional pitch

Regular distance between the individual teeth (e.g.: 3 tpi).

Cutting feed

Feed motion of the cutting tool towards the workpiece.

Cutting speed

Speed of the cutting tool in m/min.

Deviation of the tool

The cutting tool moves away from the ideal cutting line, the cut is not straight anymore (e.g. because the saw blade is worn)

Feed speed

Speed of the tool towards the -> WORKPIECE, measured in mm/min.

Layer cut

Simultaneous cutting of several workpieces that are clamped in one layer next to each other.

Material feed

Transport means to feed the material to be cut, used in most cases to adjust the cut-off length on automatic sawing machines

Mitre cut

Any cut unequal 90° relative to the length of the bar.

Multiple feed

Repetition of the material feed cycle until the required length is achieved.

Notching cut

The cutting tool cuts into the workpiece up to a certain pre-adjusted depth only. If the workpiece is turned afterwards, a small piece can be cut out from a large block for material tests, for example.

Polymer concrete

Machine tool material bound with the aid of reaction resin, e.g. PMMA (Polymethylmetacrylate). Polymer concrete has outstanding damping properties.

Refraktometer

Measuring instrument by means of which the mixing ratio of the coolant can be determined.

Remnant piece

Remaining length of a bar that cannot be utilized due to insufficient clamping or storing possibilities

Saw blade

Tool for the circular sawing machine or for the power hacksaw

Side clearance

The cutting tool could get stuck in the -->WORKPIECE if the --> WIDTH OF CUT were not slightly wider than the thickness of the cutting tool. The side clearance is achieved by the --> TOOTH SET of the cutting tool.

Tooth pitch

Measure for the tooth distance of a cutting tool. The tooth pitch is in general indicated in "teeth per inch" (tpi)

Tooth set

Alternate setting of the teeth of a tool to ensure --> SIDE CLEARANCE of the cutting tool and to achieve better chip flow

Trim cut

First cut to achieve a proper and even bar end

Variable pitch

The tooth distance between the individual teeth varies (e.g.: 3 - 4 tpi)

Width of cut

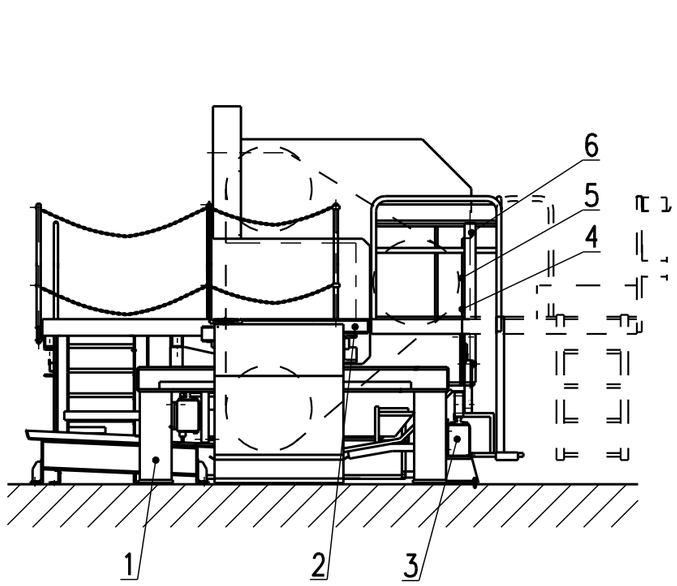
Material width that is cut "out of the material" by the cutting tool. The width of cut (and thus also the material loss) depends on the --> TOOTH SET of the cutting tool

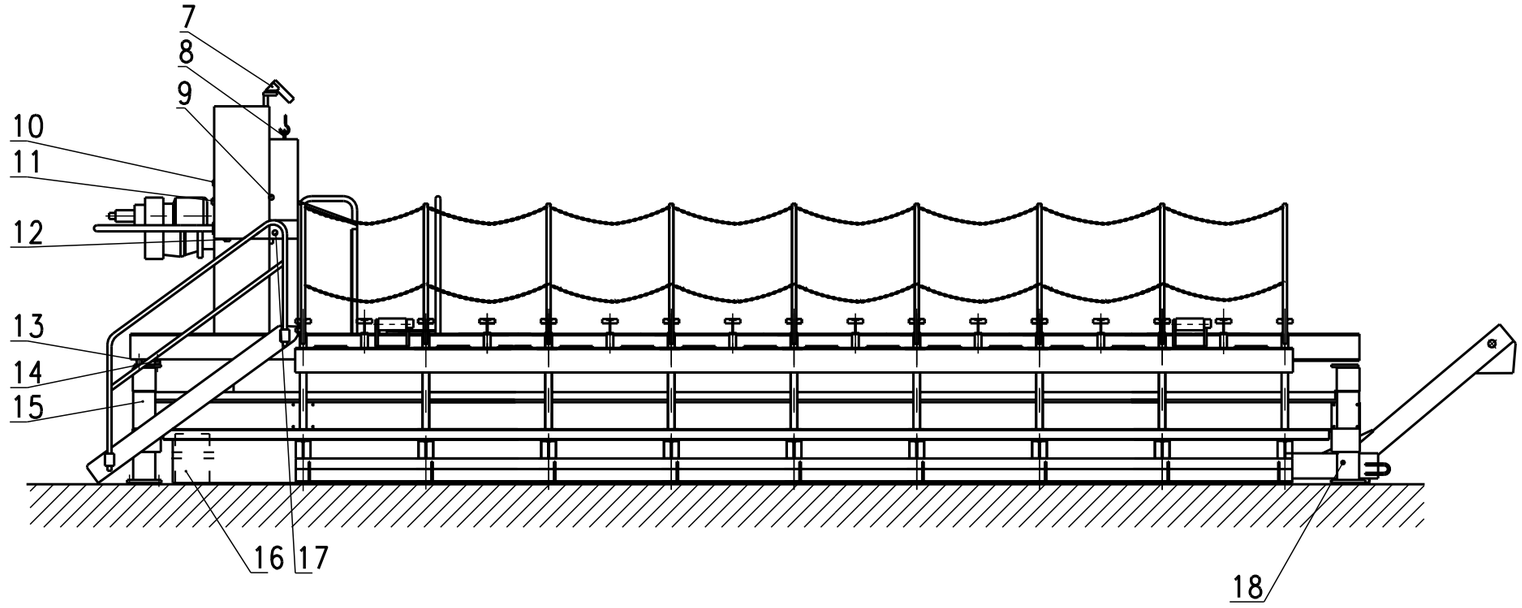
Workpiece

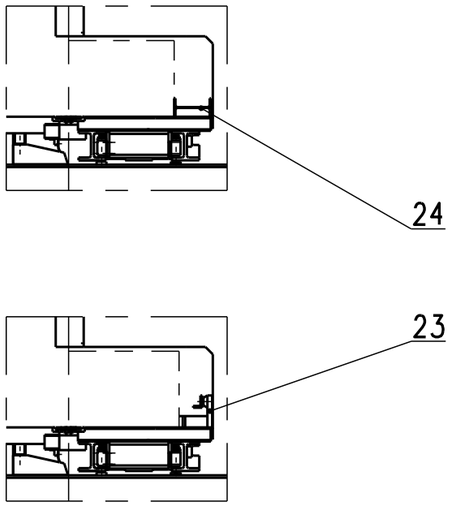
The material/bar to be machined by the sawing machine.

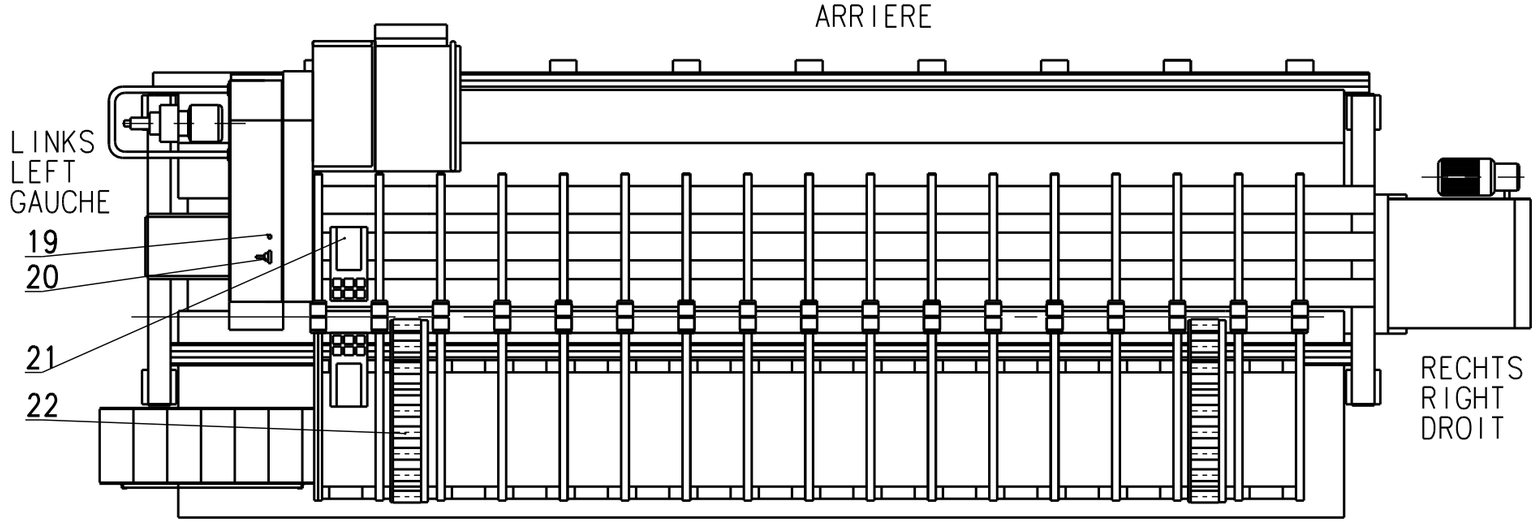
Description - General Drawing I (01466747)

1. Front table with rail I
2. Rear table
3. Rail II
4. Gear oil outletscrew
5. Gear oil sightglass
6. Gear oil filling nozzle
7. Laser lamp
8. Transport device for the saw unit
9. Stargrip to OPEN/CLOSE the protective door
10. Hydraulic oil filling nozzle
11. Hydraulic oil sightglass
12. Hydraulic oil outletscrew
13. Outer table clamping
14. Inner table clamping
15. Left column (I)
16. Coolant pump
17. Sawband guide arm / sawband guide
18. Right column (II)
19. Pressure gauge for sawband tension
20. Pressure relief valve to change the sawband tension
21. Electromechanical clamping magnet
22. Hydraulic roller rails
23. Manually adjustable measuring stop
24. Electromechanical measuring stop









ERFORDERLICHE TECHNISCHE AENDERUNGEN BEHALTEN WIR UNS VOR

SUBJECT TO NECESSARY TECHNICAL MODIFICATIONS

NOUS RESERVONS LE DROIT DE TOUTE MODIFICATION TECHNIQUE NECESSAIRE

FUER TEXT 01477900

KASTO MASCHINENBAU GMBH & CO KG
D-7590 ACHERN-GAMSHURST
INDUSTRIESTRASSE 14

KASTO

BBS 560/1060
AB SERIE 106

ÜBERSICHT II 01466747
OPERATION PLAN I
VUE D'ENSEMBLE I

30.07.90 PUSCH 00051100,01466747

Description - General Drawing II (01487701)

1. Indicator light - clamping magnet "ON"
2. Band Deviation Control (Option)
3. Indicator light - clamping magnet "ON" (addit. set)
4. Band Deviation Control "ON/OFF"
5. LED-Display - cutting depth
6. Reserve
7. Cutting depth counter "ON/OFF"
8. Reserve
9. LED-display - cutting speed
10. LED-display - cutting feed
11. Cutting speed "FASTER"
12. Cutting speed "SLOWER"
13. Speed selector switch - cutting speed (Option)
14. Speed selector switch - cutting feed

    I = 0.7 - 27 mm/min (0.03" - 1.1"/min)
    II = 0.7 - 210 mm/min (0.03" - 10.6"/min)

15. Adjustment of cutting feed
16. Saw Unit "FORWARD"
17. SAw Unit "RAPID"
18. Sawband "ON"
19. Sawband "OFF"
20. Saw Unit "BACKWARD"
21. Fault indicator
22. Inching push button - press this push button and push button 20 (= saw unit "BACKWARD") simultaneously to remove the saw unit from the workpiece with the saw band running

23. Coolant switch

    0 = no coolant delivery
    I = coolant delivery only while sawband is running
    II = permanent coolant flow (e.g. for cleaning)

24. Band guide arm "LIFT/LOWER"

25. Fault indicator - no coolant supply

26. Reserve

27. Reserve

28. Reserve

29. Reserve

30. Coolant heating

31. Hydraulic-oil heating

32. Adjustment of the sawband tension (option)

    I = 65 bar
    II = 80 bar

33. Clamping magnet "ON/OFF" (integrated indicator light flashes during magnetizing/demagnetizing process)

34. Clamping magnet "ON/OFF" (integrated indicator light flashes during magnetizing/demagnetizing process)

35. Reserve

36. EMERGENCY-OFF

37. Laser lamp "ON/OFF"

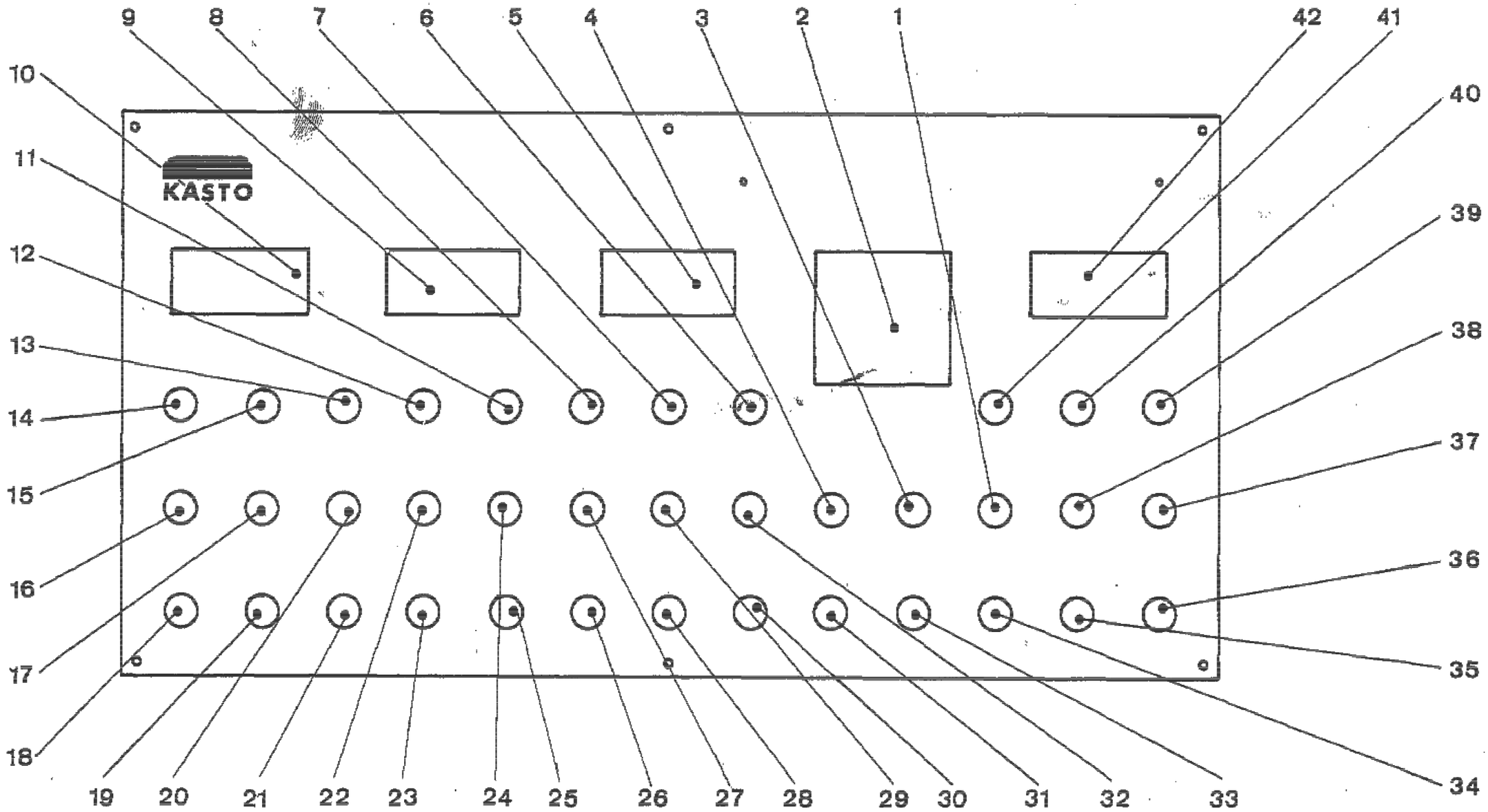
38. Reserve

39. Adjustment of measuring stop ('+'-direction)

40. Measuring stop "RAPID"

41. Adjustment of measuring stop ('-'-direction)

42. LED-display measuring stop



Serie 107

Buchst.	Art der Änderung	Datum	Name

	Datum	Name
gez.	15.08.89	M. Pusch
gepr.		
Norm.		

Übersicht II BBS 560/1060

Operation plan II BBS 560/1060

Vue d'ensemble II BBS 560/1060

Maßstab: %

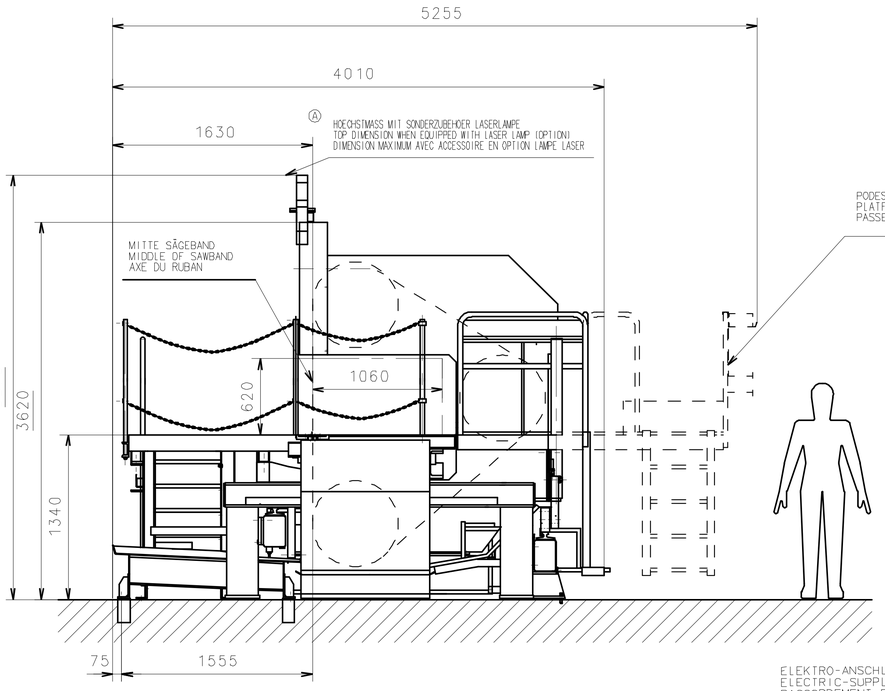
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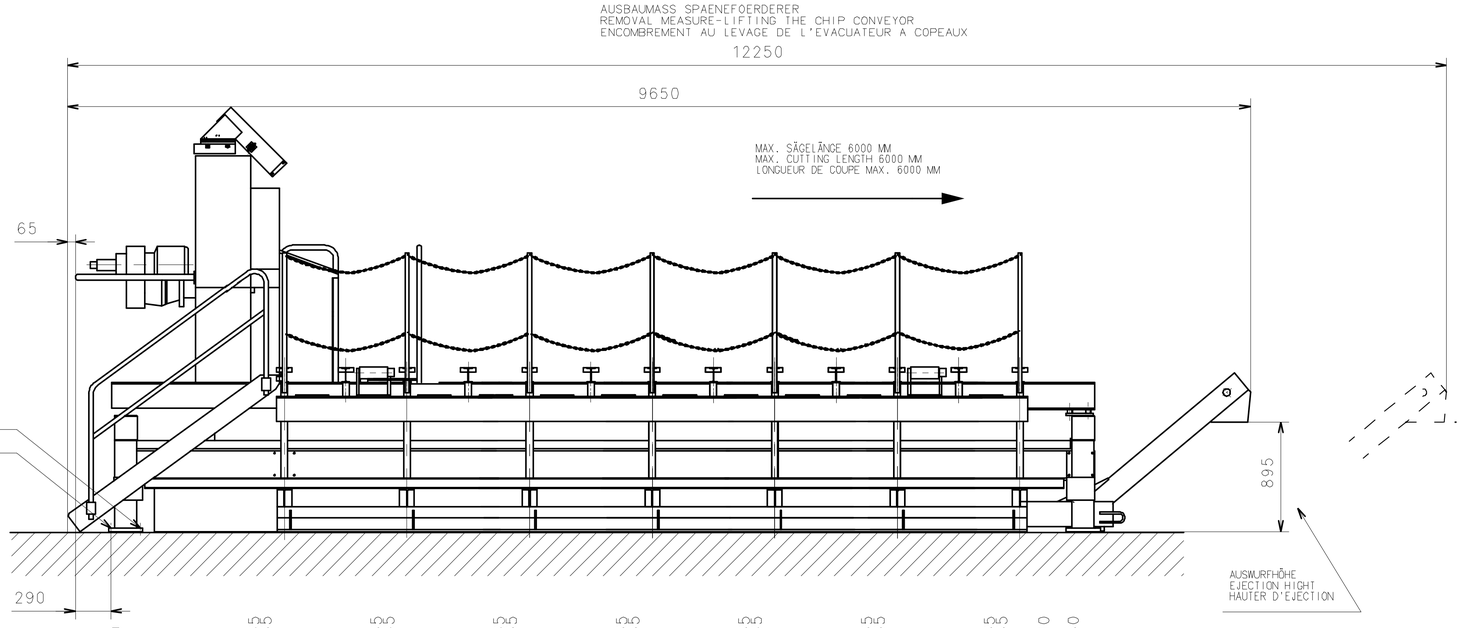
KASTO®
Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460 (PLZ 77845)
D-77855 Achern-Gamshurst

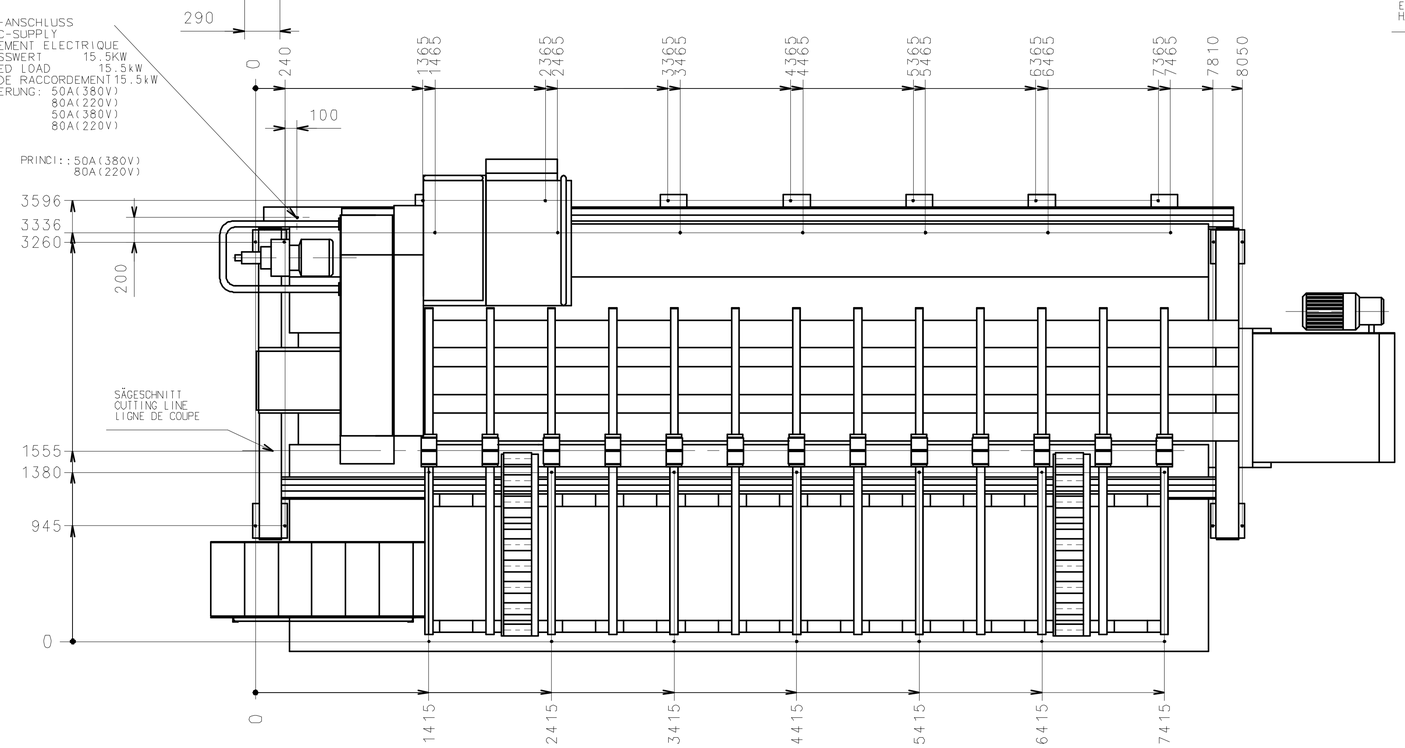
FUER DIESE ZEICHNUNG WIRD JEGLICHER RECHTSSCHUTZ IN ANSPRUCH GENOMMEN. SIE DARF UNERLAUBT WEDER KOPIERT, VERVIELFAELTIGT ODER DRITTEN MITGETEILT NOCH ANDERWEITIG MISSBRAUCHT WERDEN UND BLEIBT UNSER EIGENTUM.

ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENRAUHWERTE NACH KASTO-WERKSNORM

2 06 04



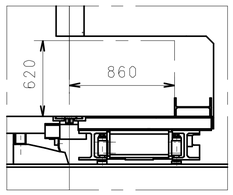




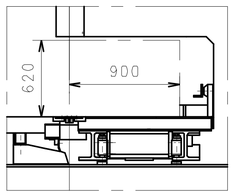
ELEKTRO-ANSCHLUSS
ELECTRIC-SUPPLY
RACCORDEMENT ELECTRIQUE
ANSCHLUSSWERT 15.5KW
CONNECTED LOAD 15.5kW
VALEUR DE RACCORDEMENT 15.5kW
VORSICHERUNG: 50A(380V)
80A(220V)
FUSE: 50A(380V)
80A(220V)
FUSIBLE
PRINCI:: 50A(380V)
80A(220V)

SCHNITTBEREICH BEI SONDERZUBEHÖR
CUTTING RANGE WITH OPTIONS
CAPACITE DE COUPE AVEC ACCESSOIRES

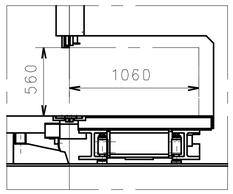
BEI ELEKTRO-MOTORISCHEM MESSANSCHLAG
CUTTING RANGE USING AN ELECTROMOTIVE MEASURING STOP
CAPACITE AVEC BUTEE DE MESURE ELECTROMECANIQUE



BEI MANUELLEM MESSANSCHLAG
CUTTING RANGE USING A MANUAL MEASURING STOP
CAPACITE AVEC BUTEE DE MESURE MANUELLE



SCHNITTBEREICH MIT BANDVERLAUFSKONTROLLE
CUTTING RANGE WITH KASTO-BAND CONTROL BC
CAPACITE DE COUPE AVEC CONTROLE DE DEVIATION DU RUBAN



ALS FUNDAMENT GENUEGT EIN NORMALER HALLENBETON DER EINE BELASTUNG VON MIN. 20000 N/M² ZULAESST. DRUCKFESTIGKEIT DER AUFLAGEPUNKTE MIN. 700 N/CM² BETONFESTIGKEITSKLASSE B 15

FUNDAMENTBEFESTIGUNG KLEBEANKER M 16 MIT ANKERSTANGEN M 16X190

AS A FOUNDATION A NORMAL HALL CONCRETE FLOOR WITH A CARRYING CAPACITY OF MIN. 20000 N/M² WILL BE SUFFICIENT RESISTANCE TO PRESSURE OF THE POINTS OF SUPPORT MIN. 700 N/CM² CONCRETE PROPERTY CLASS B 15

ANCHORING MATERIAL GLUE ANCHOR M 16 WITH ANCHOR RODS M 16X190

POUR LES FONDATIONS, IL SUFFIT D' UN SIMPLE SOL DE HALL SUPPORTANT UNE PRESSION DE 20000 N/M² MINI. RESISTANCE A LA PRESSION DES POINTS DE CHARGE 700 N/CM² MINI. RESISTANCE DU BETON CLASSE B 15

MATERIEL D'ANCRAGE CHEVILLES MAINTENUES PAR RESINE SYNTHETIQUE M 16 AVEC TIGE D'ANCRAGE M 16X190

MASCHINENGEWICHT CA.16500kg
MACHINE WEIGHT APPROX.16500kg
POIDS DE LA MACHINE ENV.16500kg

ERFORDERLICHE TECHNISCHE AENDERUNGEN BEHALTEN WIR UNS VOR

SUBJECT TO NECESSARY TECHNICAL MODIFICATIONS

NOUS NOUS RESERVONS LE DROITE DE TOUTE MODIFICATION TECHNIQUE NECESSAIRE

SAEGELAENGE 6000 mm

--					
BBS 560/1060	A	HOECHSTMASS LASERLAMPE ERGAENZT		28.3.91	PUSCH
Teilverwendung	Buchst	Art der Aenderung		Datum	Name

KASTO® Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460 (PLZ 77845)
D-77855 Achern-Gamshurst

	Datum	Name
gez	14.05.90	PUSCH
gepr.		
Norm.		

SERIE 106
FUNDAMENTPLAN BBS 560/1060
FONUDATION PLAN BBS 560/1060
PLAN DE FONDATION BBS 560/1060

Massstab: 1:25

Artikelnummer 01578138 48 1 00502

FUER DIESE ZEICHNUNG WIRD UEBLICHER RECHTSSCHUTZ IN ANSPRUCH GENOMMEN. SIE DARF UNERLAUBT WEDER KOPIERT, VERVIELFALTIGT ODER DRITTEN MITGETEILT NOCH ANDERWEITIG MISSBRAUCHT WERDEN UND BLEIBT UNSER EIGENTUM.

ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENKANTEN NACH KASTO-WERKSNORM

CAD

2 06 04

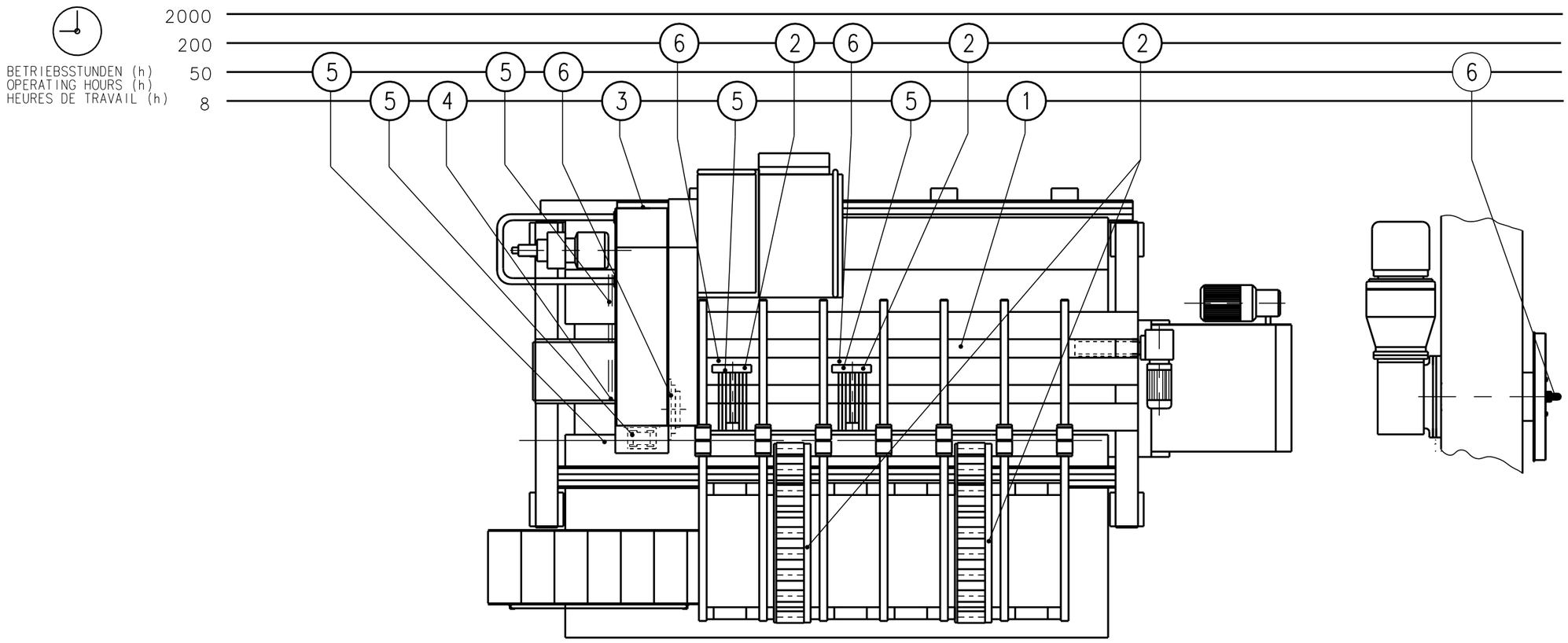
KASTO MASCHINENBAU GMBH & CO KG
INDUSTRIESTRASSE 14
77855 ACHERN - GAMSHURST

POSTFACH 1460
77845 ACHERN

KASTO®

KASTO*bbs 5x10*
TYP 6301
SERIE 106-108

SCHMIERANWEISUNG 00901857
LUBRICATION INSTRUCTIONS
INSTRUCTIONS DE GRAISSAGE



MASCHINENTEILE MACHINE PARTS PARTIES DE LA MACHINE	KUEHLMITTEL COOLANT LIQUIDE D'ARROSAGE	KETTEN CHAINS CHAINES	GETRIEBE GEAR MOTOR MOTO-REDUCTEUR	HYDRAULIK HYDRAULICS HYDRAULIQUE	FUEHRUNGEN GUIDES GUIDAGES	LAGER BEARINGS PALIERS
NR. DER EINGRIFFSTELLE № OF GREASING POINT № DE LA SURFACE DE GRAISSAGE	1	2	3	4	5	6
BILDZEICHEN DES EINGRIFFS GRAPHICAL SYMBOL OF LUBRICATION SYMBOLES DE GRAISSAGE ART DES EINGRIFFS TYP OF LUBRICATION MODE DE GRAISSAGE						
PRÜFEN UND EVTL. NACHFÜLLEN (h) CHECK AND REFILL IF NECESSARY (h) CONTROLER ET REMPLIR EVENT.(h)	8		8	8		
REINIGEN UND SCHMIEREN (h) CLEAN AND LUBRICATE (h) NETTOYER ET GRAISSER (h)		200			8	50
SCHMIERSTOFFBEZEICHN. NACH DENOMINATION OF LUBRICANT ACC.TO DENOMINATION DE LA GRAISSE SELON DIN 51502, NOV. 1979, (40°C)	KONZENTRAT CONCENTRATE CONCENTRE	BB=5000	CLP 220	HLP46	CGLP68	K3N
FUELLMENGE (l) REQUIRED QUANTITY (l) VOLUME DE REMPLISSAGE (l)	①		19	17		

①

SAEGELAENGE (mm) CUTTING LENGTH (mm) LENGUEUR DE COUPE (mm)	3000	4000	5000	6000	7000	8000
BEHAELTERKAPAZITAET (l) COOLANT CONTENT (l) CAPACITE DU BAC (l)	330	400	470	540	610	680

ACHTUNG : VOR DER SCHMIERUNG ALLE EINGRIFFSTELLEN REINIGEN
OEL- UND KÜHLMITTELSTAND LAUFEND ÜBERWACHEN KÜHLMITTEL EVTL. FROSTSCHUTZ ZUGEBEN

ATTENTION: CLEAN ALL GREASING POINTS BEFORE LUBRICATING
CHECK OIL AND COOLANT LEVEL REGULARLY ADD ANTIFREEZE TO THE COOLANT IF NECESSARY

ATTENTION: AVANT LUBRIFICATION, NETTOYER TOUTES LES SURFACES DE GRAISSAGE
CONTROLER EN PERMANENCE LE NIVEAU D'HUILE ET DU LIQUIDE D'ARROSAGE
AJOUTER EVENTUELLEMENT UN ANTIGEL AU LIQUIDE D'ARROSAGE

Mat.-Nr. 00901857 3 000505
Datum: 07.05.1990 Name: PUSCH M.

KASTO®

00939722 - 2000 1/2

SCHMIERSTOFFTABELLE LUBRICATION CHART TABLEAU DE GRAISSAGE

Bezeichnung Designation Désignation DIN 51 502	Hydrauliköle nach DIN 51 524	Umlauföle nach DIN 51 517	Viskosität in Viscosity in Viscosité en mm²/s/40°C	BP	Castrol	Esso	Mobil	oest	elf	ARAL	Shell
HLP 22 HLPD 22	X		22	BP Energol HLP-HM 22 BP Energol HLP-D 22	Castrol Hyspin AWS 22 Castrol Hyspin SP 22 Castrol Hydrauliköl HLPD 22 SF	NUTO H 22 HLPD OEL 22	Mobil DTE 22	Hydrauliköl H-LP 22 Hydrauliköl 22 DD	ELFOLNA 22 ELFOLNA DS 22 ELFOLNA HLPD 22		Shell Tellus Öl 22 Shell Hydrol DO 22
HLP 46 HLPD 46	X		46	BP Energol HLP-HM 46 BP Bartran HV46 BP Energol HLP-D 46	Castrol Hyspin AWS 46 Castrol Hyspin SP 46 Castrol Vario HDX 46 Castrol Hydrauliköl HLPD 46 SF	NUTO H 46 HLPD OEL 46	Mobil DTE 25 Mobil DTE 15 M Hydrauliköl HLPD 46	Hydrauliköl H-LP 46 Hydrauliköl 46 DD	ELFOLNA 46 ELFOLNA DS 46 ELFOLNA HLPD 46		Shell Tellus Öl 46 Shell Hydrol DO 46
CLP 46/68		X	46/68	BP Energol GR-XP 46		SPARTAN EP 68	Mobilgear 626		ELFOLNA 46 REDUCTELF SP68	Aral Degol BG 46	Shell Omala Öl 68
CLP 100		X	100	BP Energol GR-XP 100	Castrol Alpha SP 100 Castrol Alpha MW 100	SPARTAN EP 100	Mobilgear 627	Gearol C-LP 100	REDUCTELF SP100		Shell Omala Öl 100
CLP 220		X	220	BP Energol GR-XP 220	Castrol Alpha SP 220 Castrol Alpha MW 220	SPARTAN EP 220	Mobilgear 630 Mobilgear SHC 220	Gearol C-LP 220	REDUCTELF SP220 REDUCTELF SYNTHESE 220		Shell Omala Öl 220
CLP 320		X	320	BP Energol GR-XP 320		SPARTAN EP 320	Mobilgear 632		REDUCTELF SP320	Aral Degol BG 320 Degol TU 320	Shell Omala Öl 320
CLP 460		X	460	BP Energol GR-XP 460	Castrol Alpha SP 460 Castrol Alpha MW 460	SPARTAN EP 460	Mobilgear 634 Mobilgear SHC 460	Gearol C-LP 460	REDUCTELF SP460 REDUCTELF SYNTHESE 460		Shell Omala Öl 460
CGLP 68		X	68	BP Macurat 68 D BP Energol HP-C 68	Castrol Magnaglide D 68	FEBIS K 68	Mobil Vactra Oil No.2	Gleitöl CG 68	ELF MOGLIA HDE 68 ELF MOGLIA HXE 68		Shell Tonna Öl S 68 Shell Tonna Öl T 68
• BB-V • BB		X	~	*BP Energol WRL		CAZAR-K 1		*Hochleistungs-Zahnradspray	*ELF CARDREXA GR1-AL *ELFNERA 400 Y		°Shell Cardium Compounder C
HL / CL 22		x	22	BP Energol HLP-HM 22	Castrol Hyspin AWS 22 Castrol Hyspin SP 22 Castrol Hydrauliköl HLPD 22 SF	***SPIN-ESSO 22	***Mobil Velucite Oil No. 10 ***Mobil DTE 22	***Mehrzweckől 22	ELF POLYTELIS 22		***Shell Tellus Öl 22

* Mit Lösungsmittel
*** Wartungseinheit
° Ohne Lösungsmittel
• Bitumenhaltig

* With solvent
*** Maintenance unit
° Solvent free
• Contains bitumen

* Avec détergent
*** Unité d' entretien
° Sans détergent
• Contiens du bitume

SCHMIERSTOFFTABELLE LUBRICATION CHART TABLEAU DE GRAISSAGE

Schmierfette nach: lubricating greases acc.: lubrifiants graisses suivant: DIN 51 502	Konsistenzklasse: Consistency class: Classe de consistance: NLGI	BP	Castrol	Esso	Mobil	oest	elf	ARAL	Shell
GPPG 00 G-40 GP 00 G-40 G 000 K-40	NLGI 00 NLGI 00 NLGI 000	BP Energrease PR-EP 00 BP Energrease PR-EP 00	Castrol CLS Grease	FLIESSFETT S 420	Glygoyle-Grease 00 Mobilplex 44 Mobilux EP 23	Mehrzweckfett LT 00 EP	ELF MULTI BT 000		Shell Spezial Getriebefett H
K 3 N-30 K 3 P-30	NLGI 3	BP Energrease LS 3	Castrol Spheerol EPL 3	BEACON 3 UNIREX N 3	Mobilux 3	Mehrzweckfett LT 190 Mehrzweckfett LT 190 EP 3	STATERMELF EP 2 (NLGI 2)	Aral Aralub HL 2	Shell Alvania Fett R 3 Shell Alvania Fett G 3
K 2 K-20	NLG 2	BP Energrease LS 2		BEACON 2	Mobilux 2		ELF MULTI 2		Shell Alvania Fett R 2
KF 2 K-20	NLGI 2	BP Energrease L 21 M	Castrol Spheerol AP 2	ESSO MULTI-PURPOSE GREASE (MOLY) ESSO Mehrzweckfett M GELENKFETT 2-083	Mobilgrease Special	Mo S_2 - Fett	ELF MULTI MOS 2 ELF SPEZIAL MOS 2		Shell Retinax AM (LF) II

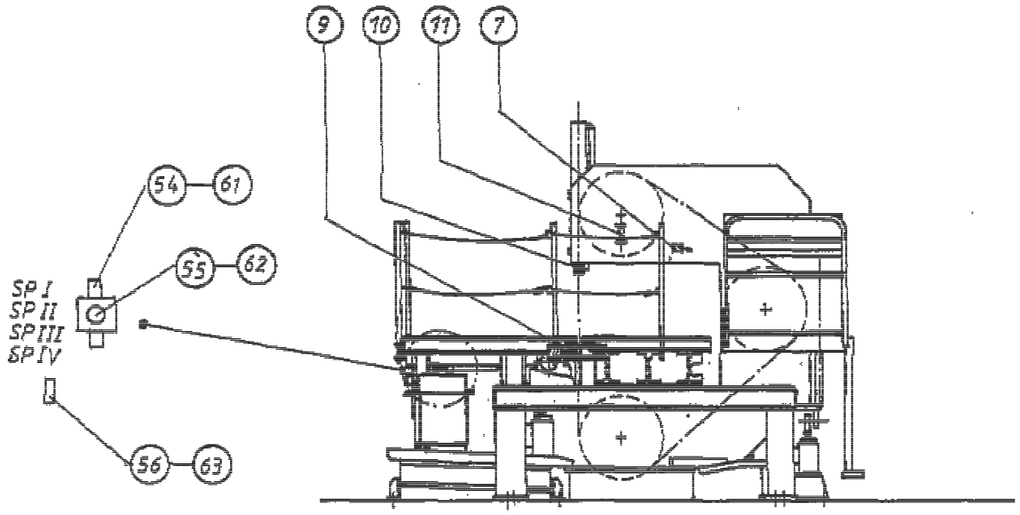
Schneidekonzentrat Cutting Concentrate Concentré de coupe	KASTO® Schneidekonzentrat Behälter / Art.-Nr. 20 Kg / 1528602 5 Kg / 1884484	** BP Ferado H ** BP Ferado M ** BP Ferado Ultracut	Castrol Hysol RD Castrol Alusol B	**KUTWELL - 40 **KUTWELL - BR 40	**Mobilmet 110 **Mobilmet 151		**ELF SPIRIT -Reihe **EMULSELF FBB		**Shell Dromus ÖL-B **Shell KS Fluid D

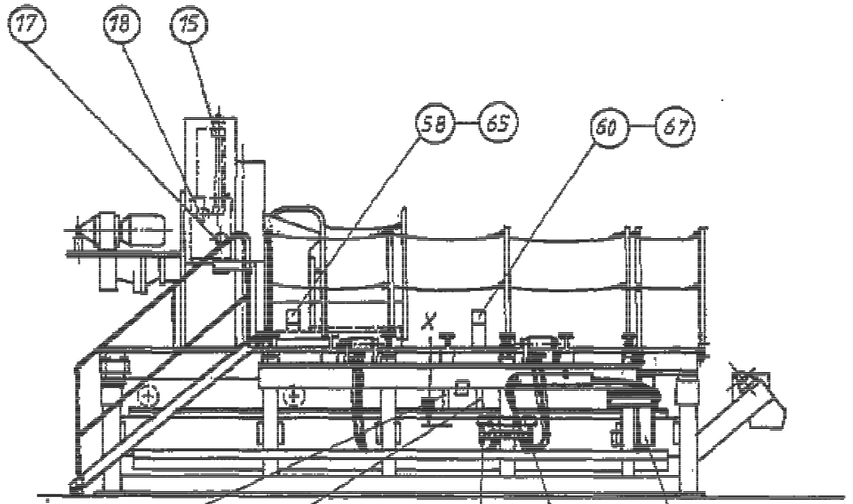
Sprühkühlmittel Cutting lubricant Lubrifiant de coupe	KASTO®	MKU
	KA 0204	Dionol Extra V1115

** Information über Einsatz, Handhabung, Mischverhältnis und Entsorgung siehe Betriebsanleitung, Produktbeschreibung oder Sicherheits-Datenblatt.

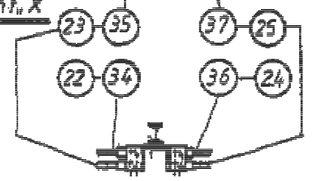
** For information on the use, handling, mixing ratio and disposal, please refer to the Operating Instructions, the Product Identification, or the Safety Data Sheet.

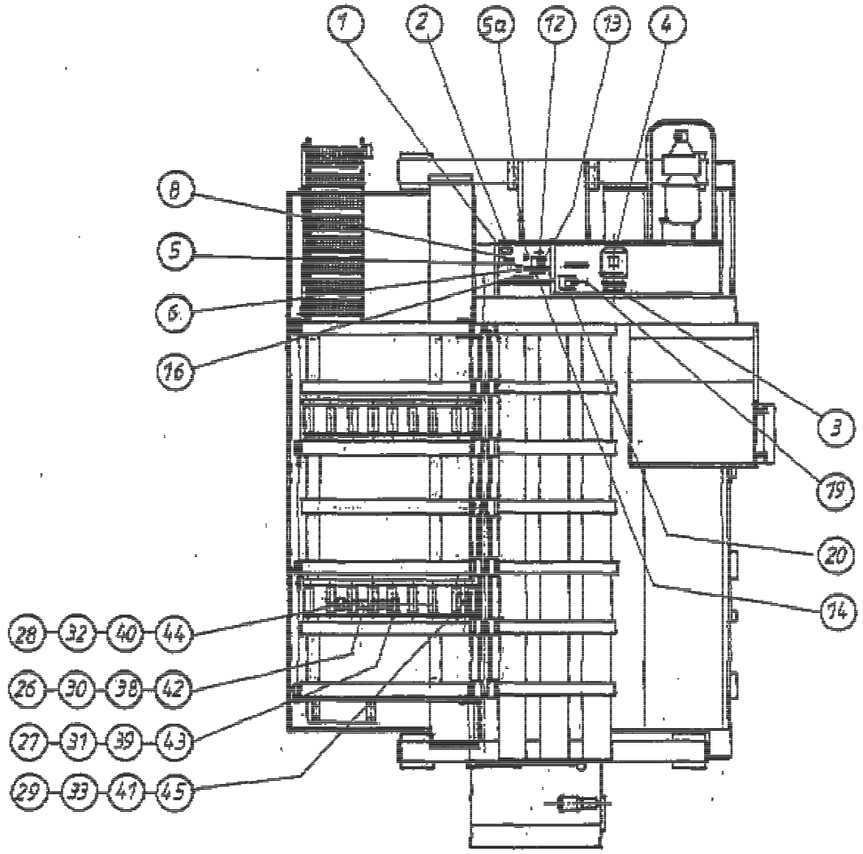
** Pour précisions concernant emploi, manipulation, rapports de dilution et stockage, voir la notice d'instructions, les consignes du fabricant ou les précautions d´ utilisation.





Teilansicht „X"





zu Hydraulikplan. 01 021 877, 01933752
for hydraulic plan.
pour schéma hydraulique.

Teileverwendung:	Buchst.	Art der Änderung	Datum	Name
		Pos. 54 bis 67 neu hinzu	4.7.92	Busch M.

	Datum	Name
gez.	10.07.89	Hertz H.
gepr.		
Norm.		

KASTO®
Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460 (PLZ 77845)
D-77855 Achern-Gamshurst

Maßstab: 1:50

AB SERIE 106

Hydrauliklageplan BBS 560/1060

Hydraulic layout

Plan des éléments hydrauliques

Teile-Nr. 01 468 782 48 3 00503

FUER DIESE ZEICHNUNG WIRD GESETZLICHER RECHTSSCHUTZ IN ANSPRUCH GENOMMEN. SIE DARF UNERLAUBT WEDER KOPIERT, VERVIELFAELTIGT ODER DRITTEN MITGETEILT NOCH ANDERWEITIG MISSBRAUCHT WERDEN UND BLEIBT UNSER EIGENTUM.

ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENRAUHWERTE NACH KASTO-WERKSNORM

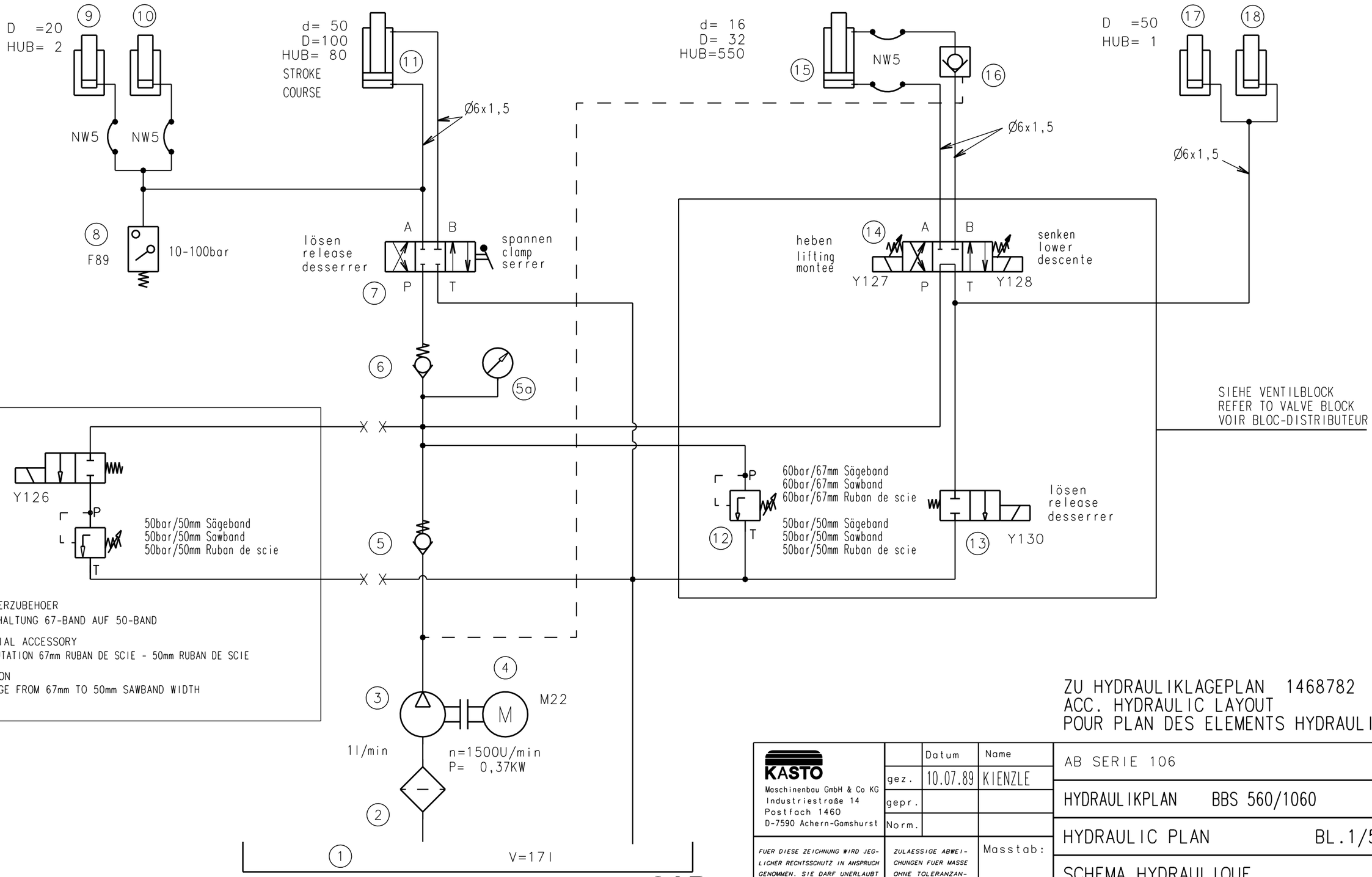
2 06 04

BANDFUEHRUNG
BAND GUIDE
GUIDE-RUBAN

BANDSPANNUNG
BAND TENSION
TENSION DU RUBAN

BANDFUEHRUNGS-VERSTELLUNG
ADJUSTMENT OF BAND GUIDE
REGLAGE DU GUIDE-RUBAN

BANDFUEHRUNG KLEMMEN
CLAMPING OF BAND GUIDE
BLOCAGE DU GUIDE-RUBAN MOBILE



SONDERZUBEHOER
UMSCHALTUNG 67-BAND AUF 50-BAND

SPECIAL ACCESSORY
COMMUTATION 67mm RUBAN DE SCIE - 50mm RUBAN DE SCIE

OPTION
CHANGE FROM 67mm TO 50mm SAWBAND WIDTH

CAD

ZU HYDRAULIKLAGEPLAN 1468782
ACC. HYDRAULIC LAYOUT
POUR PLAN DES ELEMENTS HYDRAULIQUES

KASTO
Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460
D-7590 Achern-Gamshurst

	Datum	Name
gez.	10.07.89	KIENZLE
gepr.		
Norm.		

FUER DIESE ZEICHNUNG WIRD JEGLICHER RECHTSSCHUTZ IN ANSPRUCH GENOMMEN. SIE DARF UNERLAUBT WEDER KOPIERT, VERVIELFAELTIGT ODER DRITTEN MITGETEILT NOCH ANDERWEITIG MISSBRAUCHT WERDEN UND BLEIBT UNSER EIGENTUM.

ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENRAUHWERTE NACH KASTO-WERKSNORM

Masstab:

AB SERIE 106

HYDRAULIKPLAN BBS 560/1060

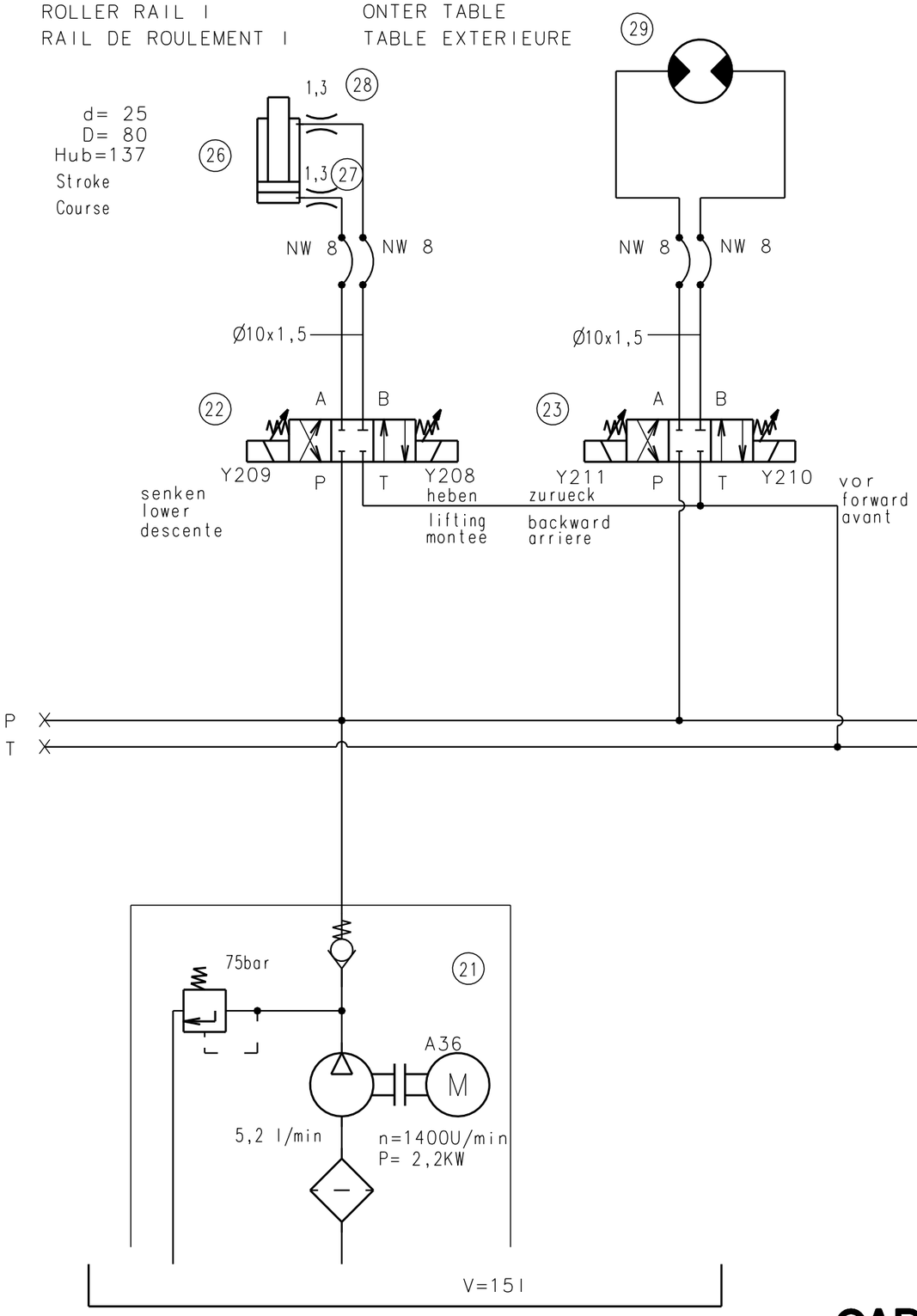
HYDRAULIC PLAN BL.1/5

SCHEMA HYDRAULIQUE

Artikelnummer
01021877 48 3 00503

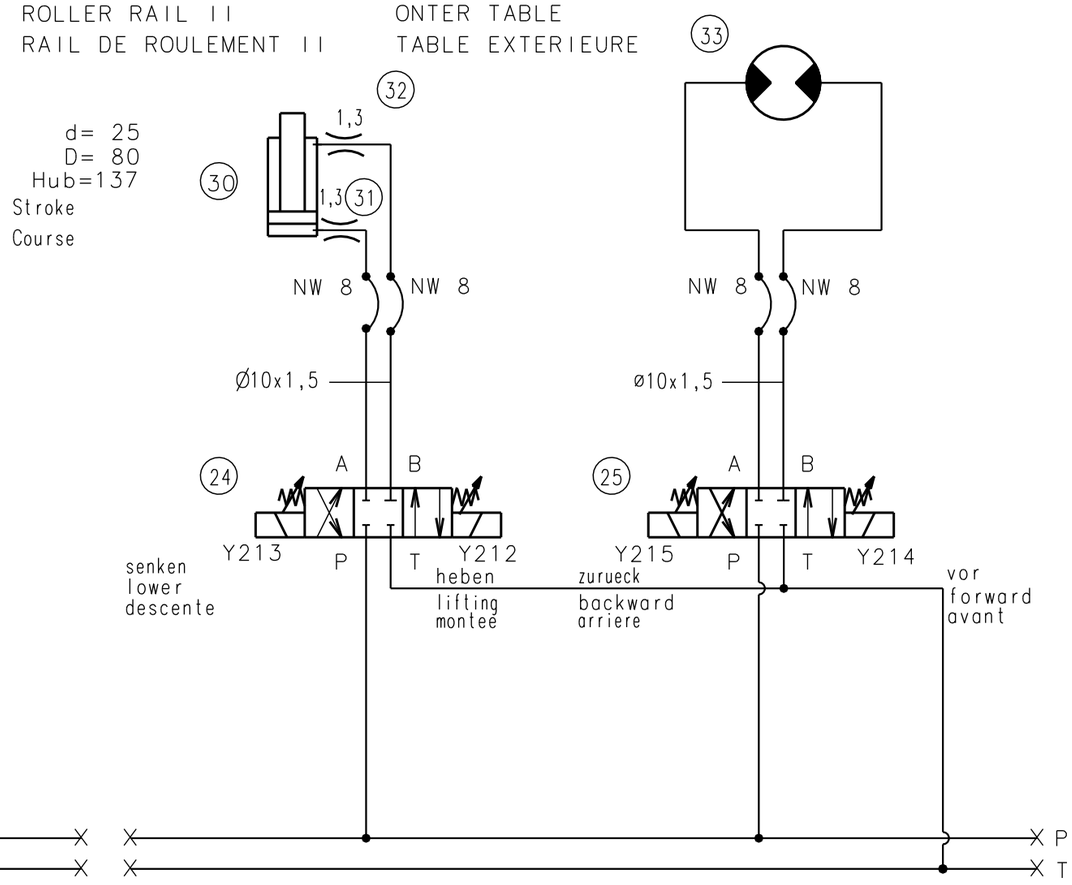
ROLLSCHIENE I
ROLLER RAIL I
RAIL DE ROULEMENT I

AEUSERER TISCH
ONTER TABLE
TABLE EXTERIEURE



ROLLSCHIENE II
ROLLER RAIL II
RAIL DE ROULEMENT II

AEUSERER TISCH
ONTER TABLE
TABLE EXTERIEURE



ZU HYDRAULIKLAGEPLAN 1468782
ACC. HYDRAULIC LAYOUT
POUR PLAN DES ELEMENTS HYDRAULIQUES

CAD

KASTO
Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460
D-7590 Achern-Gamshurst

	Datum	Name
gez.	10.07.89	KIENZLE
gepr.		
Norm.		

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ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENRAUHWERTE NACH KASTO-WERKSNORM

Masstab:

AB SERIE 106

HYDRAULIKPLAN BBS 560/1060

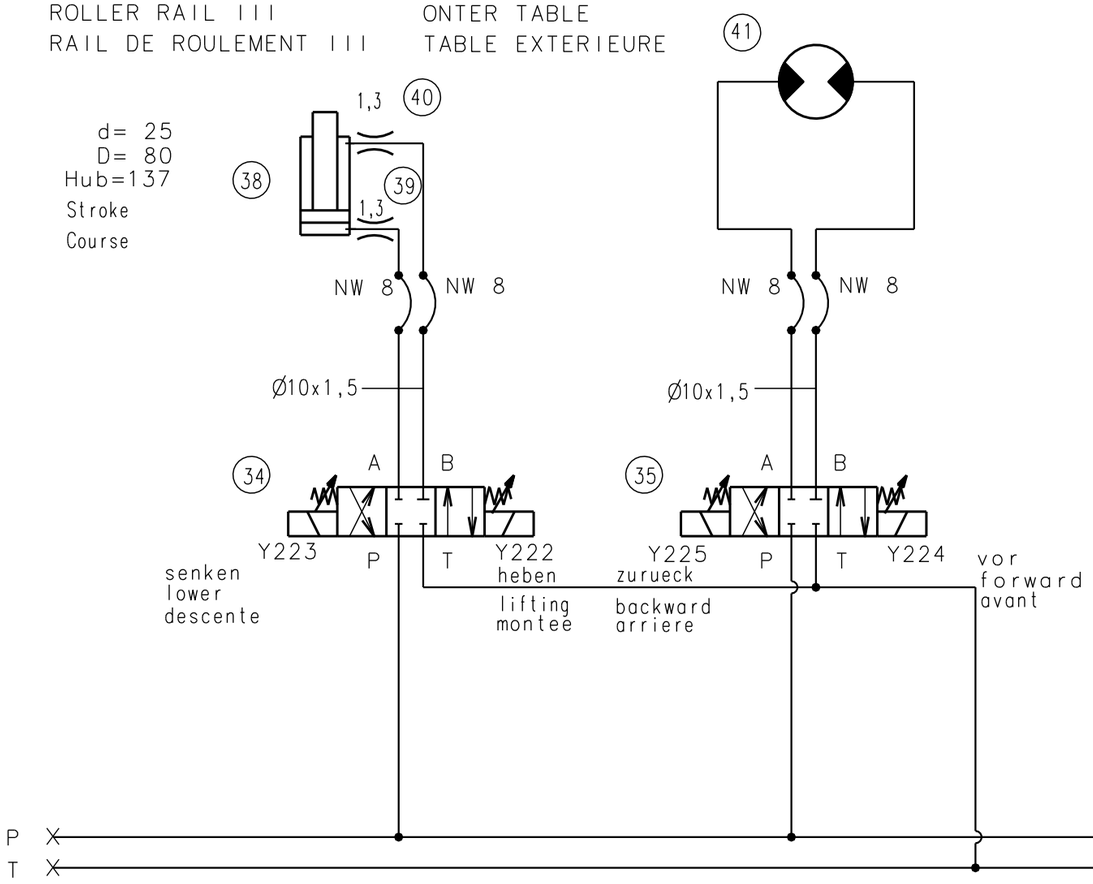
HYDRAULIC PLAN BL.2/5

SCHEMA HYDRAULIQUE

Artikelnummer
01021877 48 3 00503

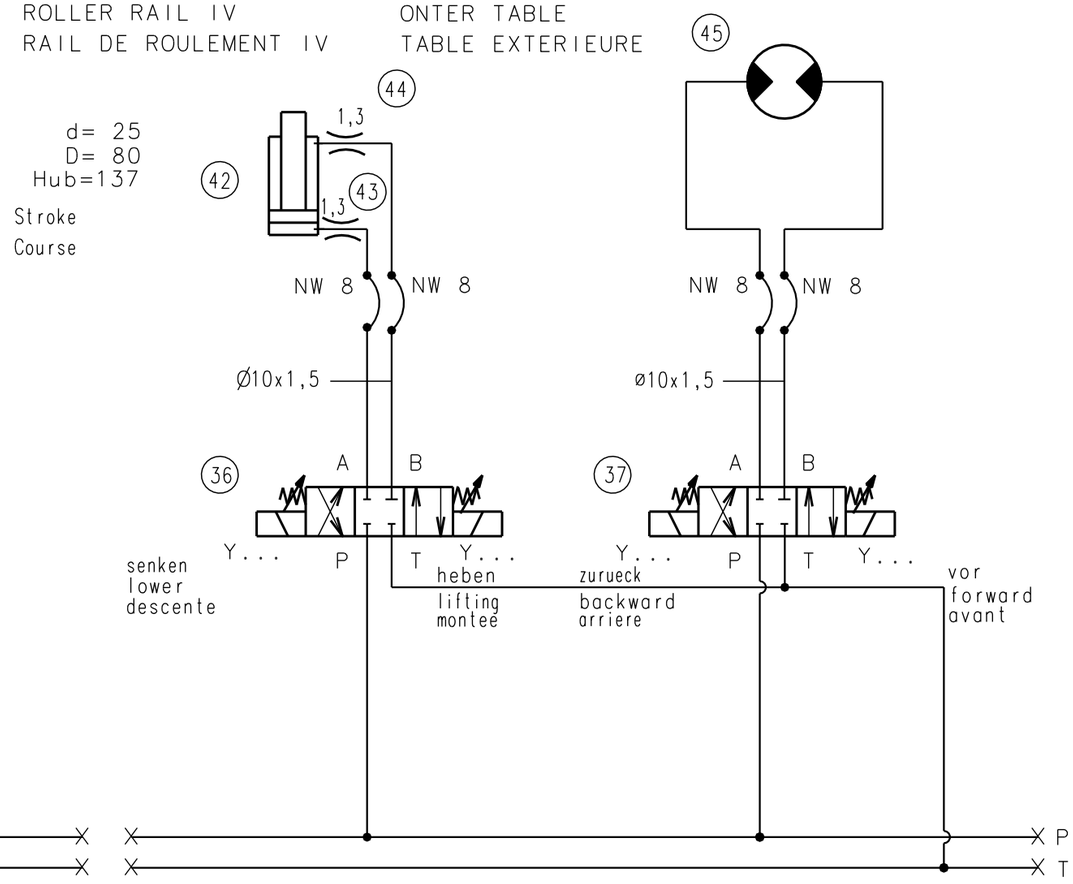
ROLLSCHIENE III
ROLLER RAIL III
RAIL DE ROULEMENT III

AEUSERER TISCH
ONTER TABLE
TABLE EXTERIEURE



ROLLSCHIENE IV
ROLLER RAIL IV
RAIL DE ROULEMENT IV

AEUSERER TISCH
ONTER TABLE
TABLE EXTERIEURE



ZU HYDRAULIKLAGEPLAN 1468782
ACC. HYDRAULIC LAYOUT
POUR PLAN DES ELEMENTS HYDRAULIQUES

CAD

KASTO
Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460
D-7590 Achern-Gamshurst

	Datum	Name
gez.	10.07.89	KIENZLE
gepr.		
Norm.		

FUER DIESE ZEICHNUNG WIRD JEGLICHER RECHTSSCHUTZ IN ANSPRUCH GENOMMEN. SIE DARF UNERLAUBT WEDER KOPIERT, VERVIELFAELTIGT ODER DRITTEN MITGETEILT NOCH ANDERWEITIG MISSBRAUCHT WERDEN UND BLEIBT UNSER EIGENTUM.

ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENRAUHWERTE NACH KASTO-WERKSNORM

Masstab:

AB SERIE 106

HYDRAULIKPLAN BBS 560/1060

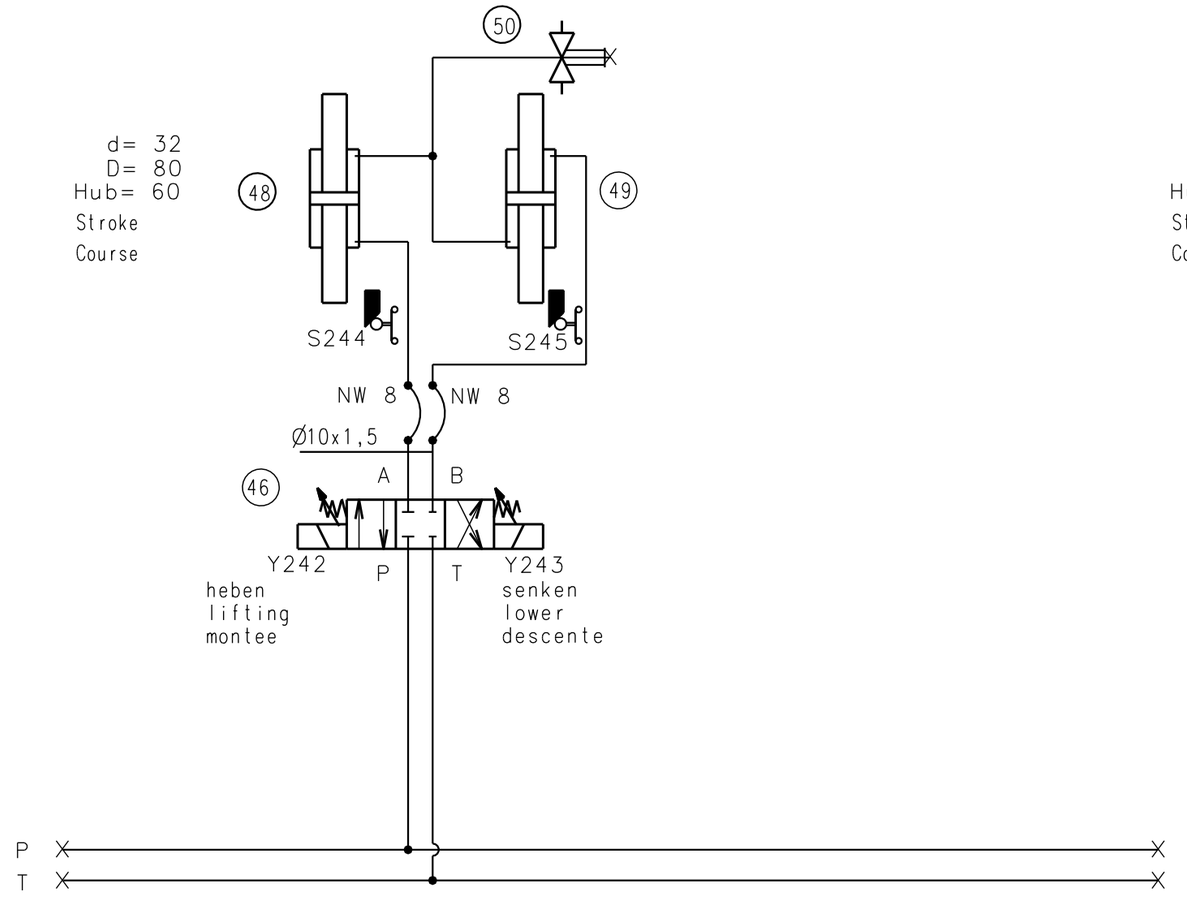
HYDRAULIC PLAN BL.3/5

SCHEMA HYDRAULIQUE

Artikelnummer
01021877 48 3 00503

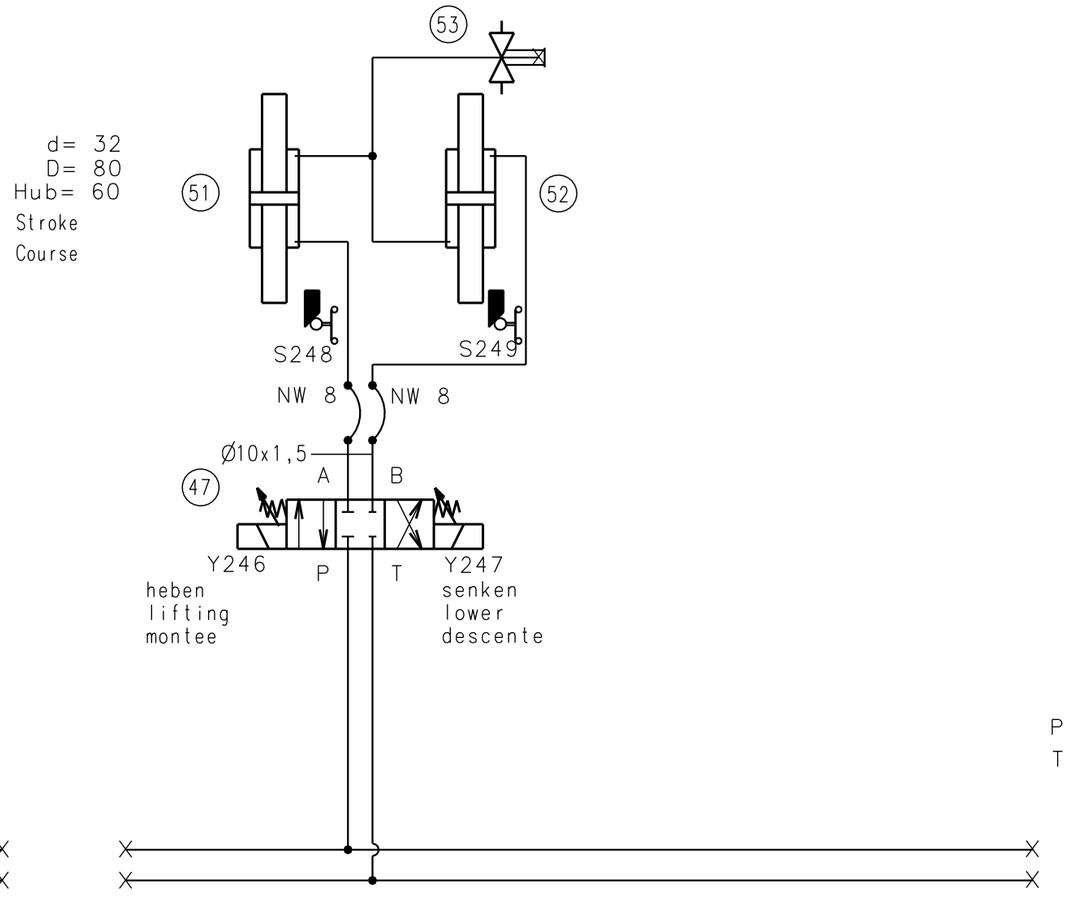
ROLLSCHIENE A
ROLLER RAIL A
RAIL DE ROULEMENT A

INNERER TISCH
INNER TABLE
TABLE INTER



ROLLSCHIENE B
ROLLER RAIL B
RAIL DE ROULEMENT B

INNERER TISCH
INNER TABLE
TABLE INTER



ZU HYDRAULIKLAGEPLAN 1468782
ACC. HYDRAULIC LAYOUT
POUR PLAN DES ELEMENTS HYDRAULIQUES

KASTO
Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460
D-7590 Achern-Gamshurst

	Datum	Name
gez.	10.07.89	KIENZLE
gepr.		
Norm.		

FUER DIESE ZEICHNUNG WIRD JEGLICHER RECHTSSCHUTZ IN ANSPRUCH GENOMMEN. SIE DARF UNERLAUBT WEDER KOPIERT, VERVIELFAELTIGT ODER DRITTEN MITGETEILT NOCH ANDERWEITIG MISSBRAUCHT WERDEN UND BLEIBT UNSER EIGENTUM.

ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENRAUHWERTE NACH KASTO-WERKSNORM

Masstab:

AB SERIE 106

HYDRAULIKPLAN BBS 560/1060

HYDRAULIC PLAN BL.4/5

SCHEMA HYDRAULIQUE

Artikelnummer
01021877 48 3 00503

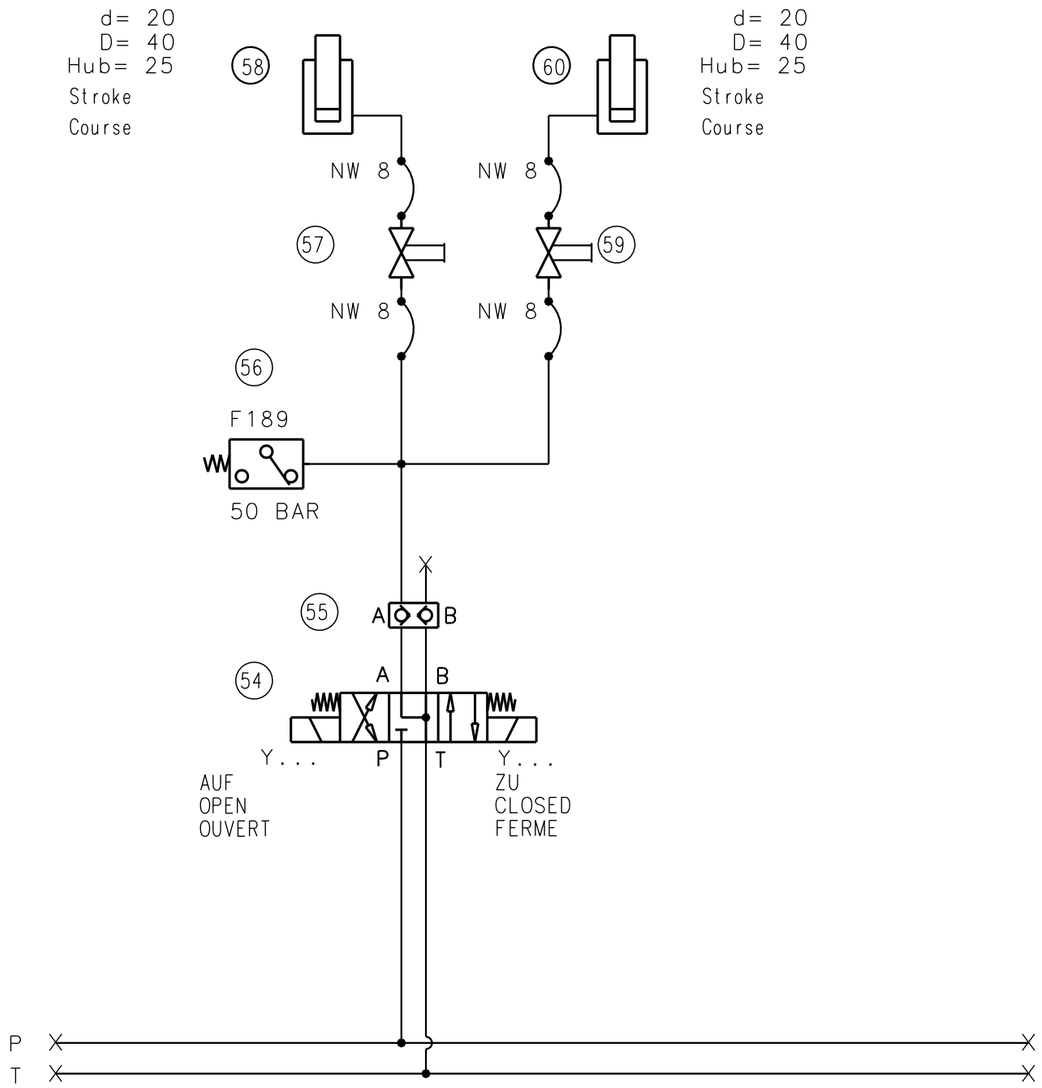
CAD

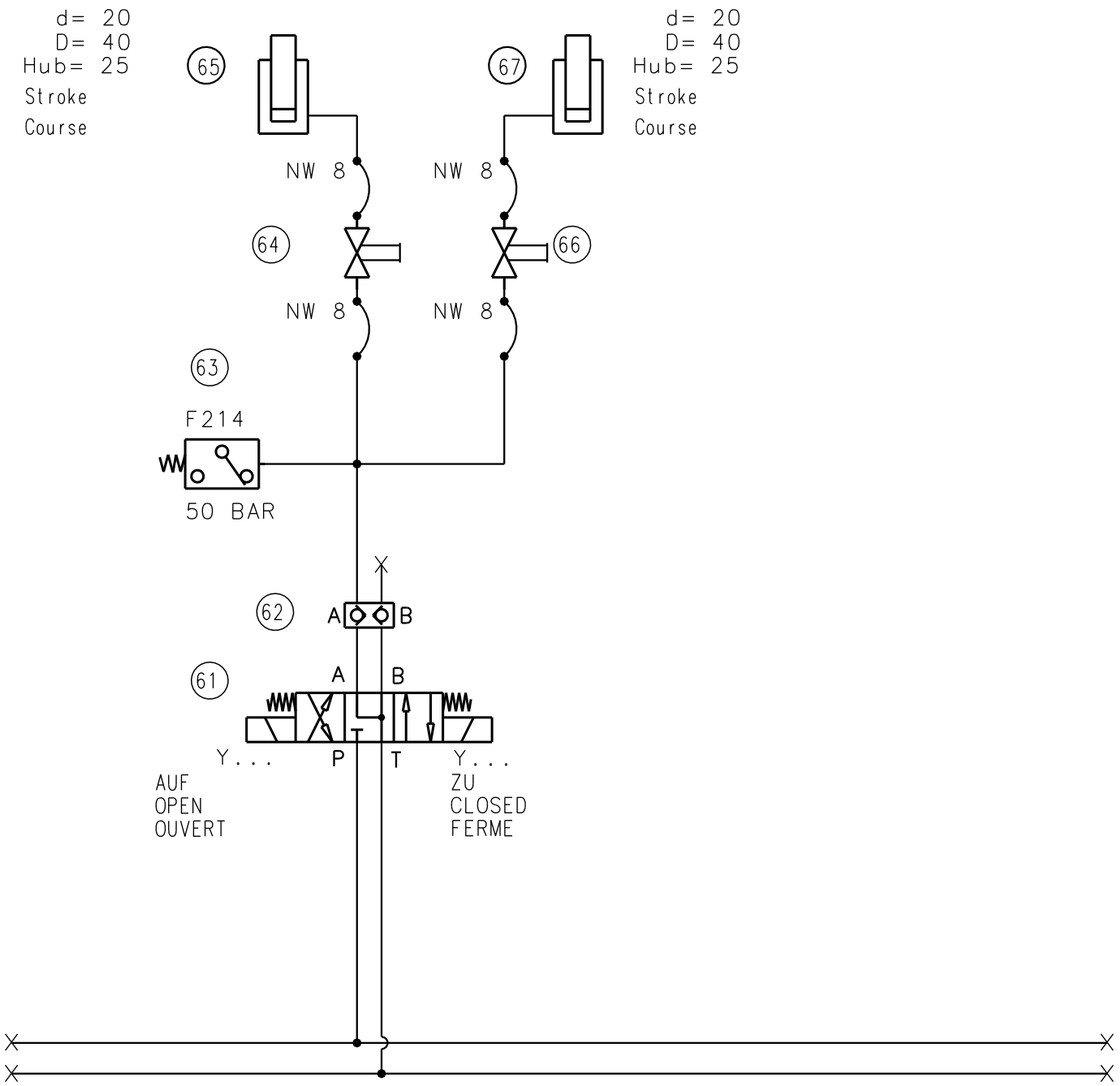
SP I
VISE I
ETAU I

SP II
VISE II
ETAU II

SP III
VISE III
ETAU III

SP IV
VISE IV
ETAU IV





ZU HYDRAULIKLAGEPLAN 1468782
ACC. HYDRAULIC LAYOUT
POUR PLAN DES ELEMENTS HYDRAULIQUES

CAD

KASTO
Maschinenbau GmbH & Co KG
Industriestraße 14
Postfach 1460
D-7590 Achern-Gamshurst

	Datum	Name
gez.	10.07.89	KIENZLE
gepr.		
Norm.		

FUER DIESE ZEICHNUNG WIRD JEGLICHER RECHTSSCHUTZ IN ANSPRUCH GENOMMEN. SIE DARF UNERLAUBT WEDER KOPIERT, VERVIELFAELTIGT ODER DRITTEN MITGETEILT NOCH ANDERWEITIG MISSBRAUCHT WERDEN UND BLEIBT UNSER EIGENTUM.

ZULAESSIGE ABWEICHUNGEN FUER MASSE OHNE TOLERANZANGABE SOWIE OBERFLAECHENRAUHWERTE NACH KASTO-WERKSNORM

Masstab:

AB SERIE 106

HYDRAULIKPLAN BBS 560/1060

HYDRAULIC PLAN BL.5/5

SCHEMA HYDRAULIQUE

Artikelnummer
01021877 48 3 00503

BLATT 5 NEU HINZU. 27.07.92 HER

Pos.	Designation	Typ	Manufact.	EDP-No.	Quty.
1.	Oil container		KASTO	951 072	1
2.	Suction filter	AS 10	Argo	23 035	1
3.	Gear pump	110/NS 1 l/min	Beinlich& Hornscheidt	329 894	1
4.	Three-phase motor		Huber& Moser	*	1
5.	Check valve	RHD 6 - L	Ermeto	349 216	1
5a.	Manometer	NG 63/R 1/4", 0-100 bar	VDO	84 700	1
6.	Check valve	RHD 6 - L	Ermeto	349 216	1
7.	4/3 direct. valve	SGOG - C	HAWE	325 686	1
8.	Pressure control	9054-10-100 bar	Suco	247 081	1
9.	Band guide cyl.		KASTO	775 487	1
10.	Band guide cyl.		KASTO	775 487	1
11.	Band clamping cyl.		KASTO	483 559	1
12.	Pressure relief valve	DB DH6 K10/100	Rexroth	366 048	1
13.	2/2 direct. valve	121 F 04	Lucifer	*	1
	3/2 direct. seat valve	M3 SEW 6 G/420 1	Rexroth	*	1
14.	4/3 direct. valve	4 WE 6 G 5X/A NZ 4	Rexroth	*	1
15.	Band guide adjusting cylinder		KASTO	751 179	1
16.	Check valve	RHZ	Integral Hydraulik	527 289	1
17.	Band guide clamping cylinder		KASTO	254 126	1
18.	Band guide clamping cylinder		KASTO	254 126	1
- OPTION -					
19.	Pressure relief valv	DB DH6 K10/100	Rexroth	366 048	1
20.	2/2 direct. valve	121 F 04	Lucifer	*	1

* refer to General Drawing - electrical Parts

Pos.	Designation	Typ	Manufact.	EDP-No.	Quty.
- OPTION -					
21	Hydraulic unit	MP 44 - Z 5,2 - B 25 A51/120	HAWE	803 243	1
22.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
23.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
24.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
25.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
26.	Lifting cyl.		KASTO	953 113	1
27.	Orifice plate 1,3		KASTO	827 754	1
28.	Orifice plate 1,3		KASTO	827 754	1
29.	Hydraulic motor	OMP 200	Danfoss	757 357	1
30.	Lifting cyl.		KASTO	953 113	1
31.	Orifice plate 1,3		KASTO	827 754	1
32.	Orifice plate 1,3		KASTO	827 754	1
33.	Hydraulic motor	OMP 200	Danfoss	757 357	1
34.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
35.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
36.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
37.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
38.	Lifting cyl.		KASTO	953 113	1
39.	Orifice plate 1,3		KASTO	827 754	1
40.	Orifice plate 1,3		KASTO	827 754	1
41.	Hydraulic motor	OMP 200	Danfoss	757 357	1
42.	Lifting cyl.		KASTO	953 113	1
43.	Orifice plate 1,3		KASTO	827 754	1
44.	Orifice plate 1,3		KASTO	827 754	1
45.	Hydraulic motor	OMP 200	Danfoss	757 357	1

* refer to General Drawing - Electrical Parts

Pos.	Designation	Typ	Manufact.	EDP-No.	Quty.
- OPTION -					
46.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
47.	4/3 direct. valve	4 WE 6 E 5X/A NZ 4	Rexroth	*	1
48.	Lifting cyl.		KASTO	952 214	1
49.	Lifting cyl.		KASTO	952 222	1
50.	Ball faucet	BKH 10 L	Argus	732 605	1
51.	Lifting cyl.		KASTO	952 214	1
52.	Lifting cyl.		KASTO	952 222	1
53.	Ball faucet	BKH 10 L	Argus	732 605	1
VICE I					
54	4/3 distr. valve	4 WE 6 J 5x	Rexroth	*	1
55	Double check valve	Z 2 S 6	Rexroth	00081434	1
56	Pressure control	9054-10-100 bar	SUCO	00247081	1
57	Kupplungsmuffe with coupling plug	SVK 7121-006-34 00 08 SVK 7101-9005-34-0076	Argus Argus	00328081 00327972	1 1
58	Clamping cylinder	ϕ40xϕ20x25		01980173	1
Vice II					
59	Coupling sleeve with coupling plug	SVK 7121-006-34-00-08 SVK 7101-9005-34-00-76	Argus Argus	00328081 00327972	1 1
60	Clamping cylinder	ϕ40xϕ20x25	KASTO	01980173	1
Vice III					
61	4/3 distr. valve	4 WE 6 J 5x	Rexroth	*	1
62	Double check valve	Z 2 S 6	Rexroth	00081434	1
63	Pressure control	9054-10-100 bar	SUCO	00247081	1
64	Coupling sleeve with coupling plug	SVK 7121-006-34 00 08 SVK 7101-9005-34-00-76	Argus Argus	00328081 00327972	1 1
65	Clamping cylinder	ϕ40xϕ20x25		01980173	1

* refer to General Drawing - electrical Parts

Pos.	Designation	Typ	Manufact.	EDP-No.	Quty.
Vice IV					
66	Coupling sleeve	SVK 7121-006-34-00-08	Argus	00328081	1
	with coupling plug	SVK 7101-9005-34-00-76	Argus	00327972	1
67	Clamping cylinder	ϕ40xϕ20x25	KASTO	01980173	1

* refer to General Drawing - Electrical Parts

Nr.	Benennung	Stück	Bestellnummer
	BAND GUIDE		
	Assy. guide, Band guide fixed		
	screwed-type	1	00775428
	Ball bearing 6208-2RS	2	00295914
	Assy. guide, Band guide fixed		
	hydr. liftable	1	00775436
	Assy. guide, Band guide moveable		
	screwed-type	1	00775479
	Assy. guide, Band guide moveable		
	hydr. liftable	1	00775460
	CHIP REMOVAL BRUSH		
	Toothed belt 150 L 050	1	00364657
	Chip removal brush	2	00332577
	BAND DEVIATION CONTROL		
	Assy. feeler	1	00779695
	CONTROL CABINET		
	Filter mat	2	00401234
	FEED DRIVE		
	Carbon brush	2	01395149
	BAND DRIVE		
	V-Belt	1	00326097

KASTO Maschinenbau GmbH & Co KG
Industriestraße 14
D-7590 Achern-Gamshurst

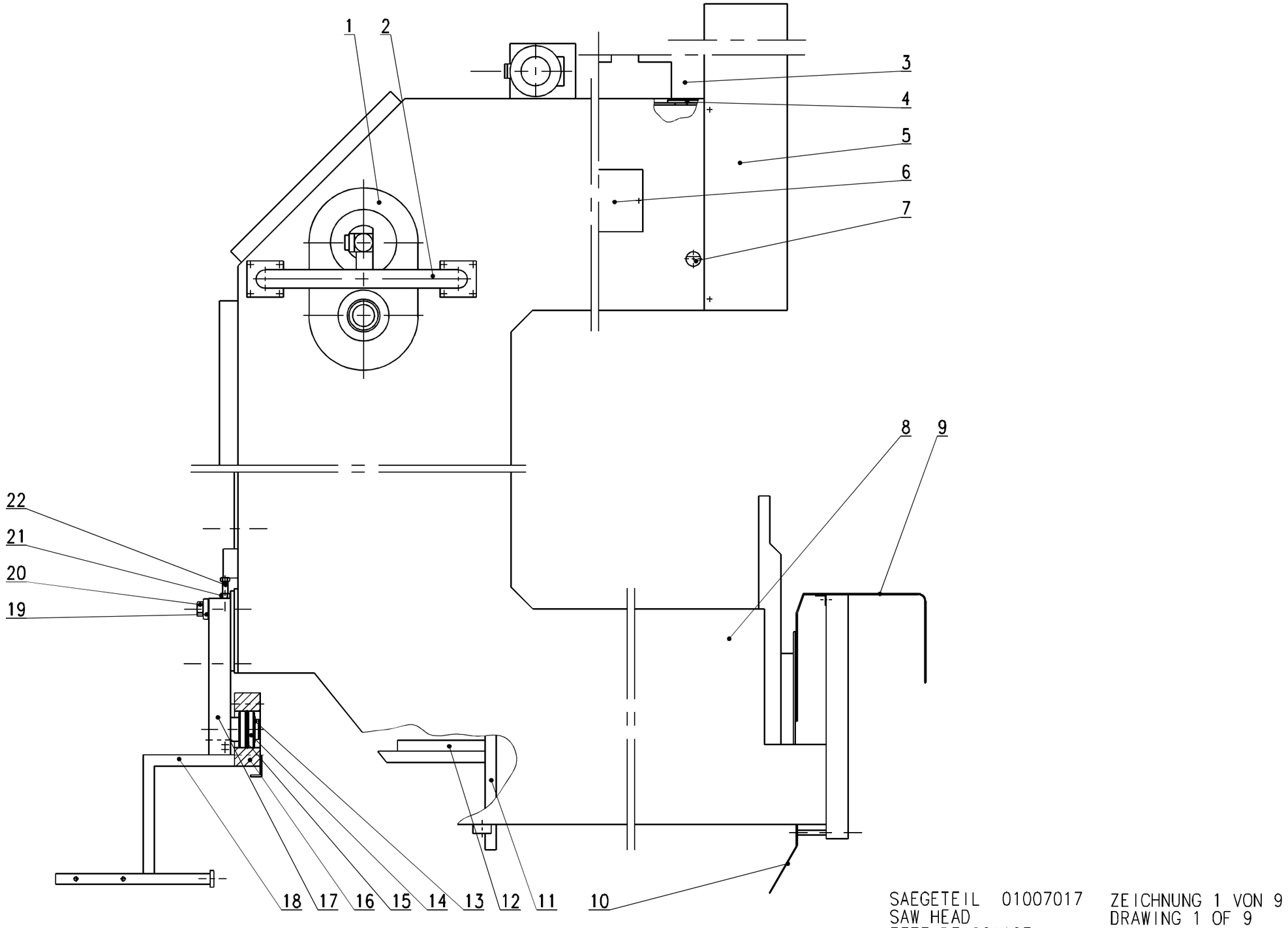
KASTO

Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 1 of 9**	
1	Gear box	1	*
2	Assy. bow	1	00560324
3	Assy. protection plate	1	00569283
4	Cover	1	00867233
5	Protective cover	1	00844861
6	Deckel	1	00736627
7	Oil sight glass SK 20.M M30 x 1,5	1	00027987
8	Assy. Machine base	1	00951072
9	Assy. protection plate	1	00844888
10	Assy. protection plate 505 long	1	00952699
	Assy. protection plate 560 long	1	00952680
11	Assy. frame		00844683
12	Steps 600x240x30	3	00709425
13	Snap ring 55 x 2,0 DIN 471	1	00257214
14	Ball bearing 6211-Z	2	00308811
15	Snap ring I 100 DIN 472	1	00086428
16	Track roller	1	00475386
17	Assy. support plate	1	00484059
18	Assy. step	1	00866458
19	Washer	4	00483400
20	Hex screw M 24 x 110-8.8	4	00484067
21	Hex nut M 16 x 1,5 DIN934-5S	1	00297690
22	Hex screw M 16x1,5x50-8.8	1	00510386

* refer to General Drawing - Electrical Parts

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Industriestraße 14
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KASTO



SAEGETEIL 01007017
SAW HEAD
FETE DE SCIAGE

ZEICHNUNG 1 VON 9
DRAWING 1 OF 9
DESSIN 1 A 9

KASTO MASCHINENBAU GMBH & CO KG
D-7590 ACHERN-GAMSHURST
INDUSTRIESTRASSE 14

KASTO

BBS 560/1060
AB SERIE 106

ERSATZTEILE
SPARE PARTS
PIECES DE RECHANGE

21.05.90 PUSCH 000501000.01007017.E01

Nr.	Benennung	Stück	Bestellnummer
	Saw unit 01007017	**Drawing 2 of 9**	
1	Limit switch	1	*
2	Grip	1	00343331
3	Allen screw M 6x16-10.9 DIN 912	2	00070807
4	Angle	1	00569259
5	Assy. protective plate	1	00563544
6	Allen screw M 12x80- 10.9 DIN 912	4	00071447
7	Plastic hose 1400 lg.	1	00368695
8	Hose clip SGL12-22/9 SKZ W 1	2	00022039
9	Hose fitting nozzle	2	00025283
10	Angle R Nr. 92 1/4"	4	00026964
11	Clamping piece	1	00361534
12	Ball fitting R1/4" Typ 3410 DIN 3511	1	00025372
13	Saucer head screw M6 x 16	2	00239534
14	Assy. holder	1	00950890
15	Cap screw GN 547		
	M 35 x 1,5 - AZ - RT	1	00950890
16	Protective plate	1	00868507
17	Protective plate L = 650	1	00569305
	Protective plate L = 620	1	00868620
18	Saucer head screw M6 x 12	17	00214566
19	Oil sightglass SK.20.M.M 30 x 1,5	1	00027987
20	Copper ring 16,5x21,5x1,5 DIN 7603 A	1	00026158
21	Cap screw R 3/8"-5S DIN 910	1	00072338
22	Control cam	1	00625361
23	Cam strip	1	00617229
24	Allen screw M6x20-10.9 DIN 912	2	00070823
25	Limit switch	4	*
26	Base plate	4	00235512
27	Assy. holder	1	00844977
28	Allen screw M8x20-10.9 DIN 912	2	00070971
29	Cover plate	1	00648477
30	Scraper BA 25	2	00316512
31	Holder	2	00668524
32	Assy. protection plate	1	00668745
*	refer to General Drawing-Electrical Parts		

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KASTO

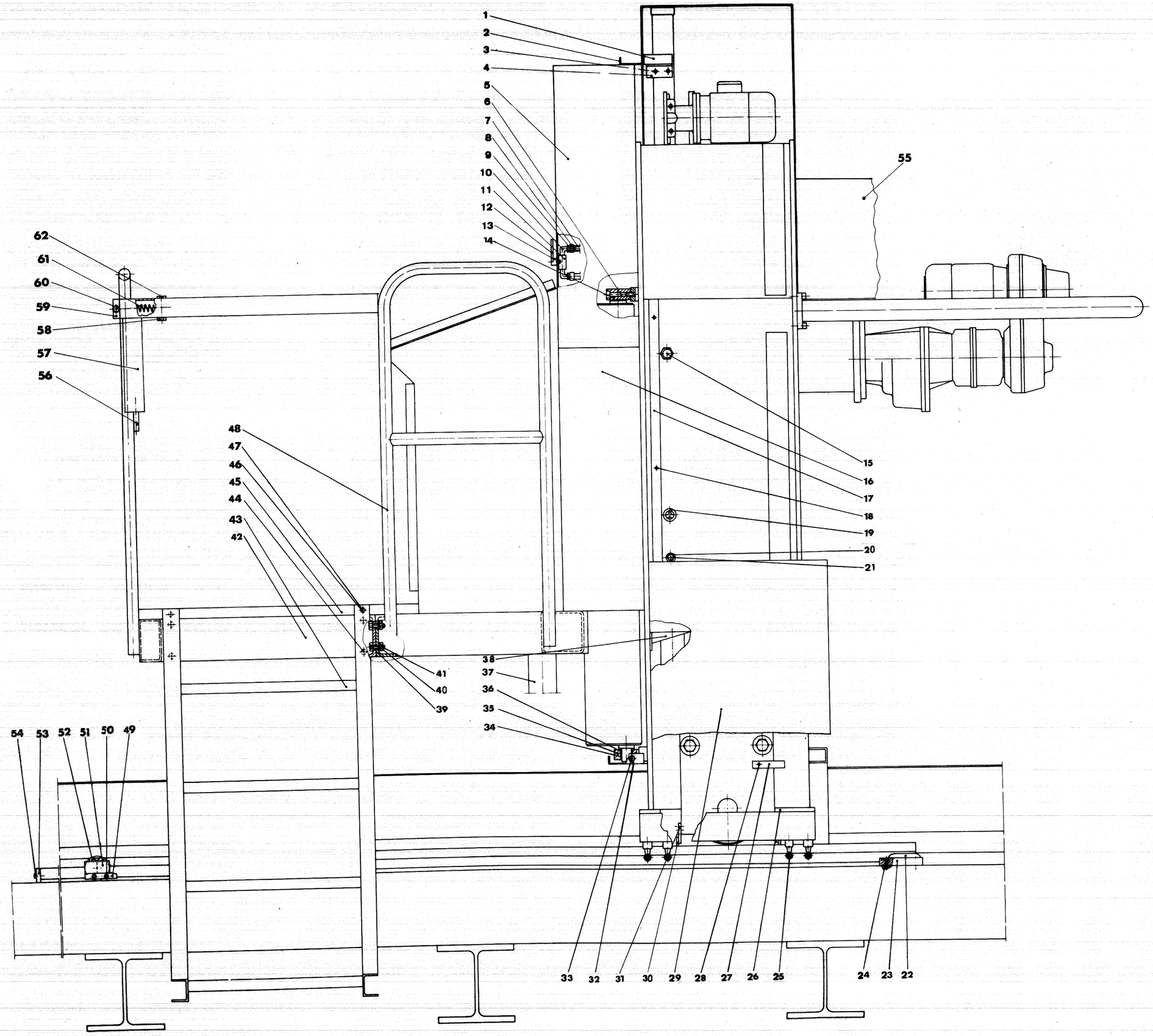
Nr.	Benennung	Stück	Bestellnummer
	Saw unit 01007017	**Drawing 2 of 9**	
33	Saucer head screw M6 x 8	2	00121029
34	DU-bushing 30/34 x 15	2	00311472
35	DU-bushing 30/34 x 16	2	00321028
36	Holder	2	00475416
37	Protective hose	1	00652563
38	Holder	1	00668516
39	Hex screw M10x25-8.8 DIN 933	4	00070343
40	Washer B 10,5 - St DIN 125	4	00072621
41	Hex nut M 10 DIN 934 5 S	4	00072435
42	Assy. frame	1	00845094
43	Assy. ladder	1	00845183
44	Allen screw M 10x16-10.9 DIN 912	4	00081108
45	Steps 1000 x 800 x 30	1	00866563
46	Allen screw M 8x16-10.9 DIN 912	2	00070963
47	Hex nut M 8 DIN 934 - 5 S	2	00072427
48	Assy.frame	1	00845213
49	Rail	1	00668176
50	Allen screw M 6x25-10.9 DIN 912	4	00070831
51	Stop	1	00668346
52	Star grip M 10 x 20 D.50 Nr.0920A	1	00142409
53	Plate	1	00686468
54	Allen screw M 6x20-10.9 DIN 912	2	00070823
55	Assy. protection cover *1	1	01888242
56	Bearing bolt *2	2	00343315
57	Assy. pipe *2	1	01932071
58	Hex nut M 8 DIN 934-5 S *2	1	01896229
59	Rail *2	1	01932101
60	Allen screw DIN 912 M8x35-10.9 *2	1	00071013
61	Tension spring 17,6x1,6x88,6 *2	1	00322954
62	Allen screw DIN 912 M8x55-12.9 *2	1	00071064

*1 Option "swillable handrail at operating panel"

*2 Option "protective bow at drive motor"

KASTO Maschinenbau GmbH & Co KG
Industriestraße 14
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KASTO



BBS 560/1060
Serie 106

Sägeteil 01007017
Saw head
Tête de sciage

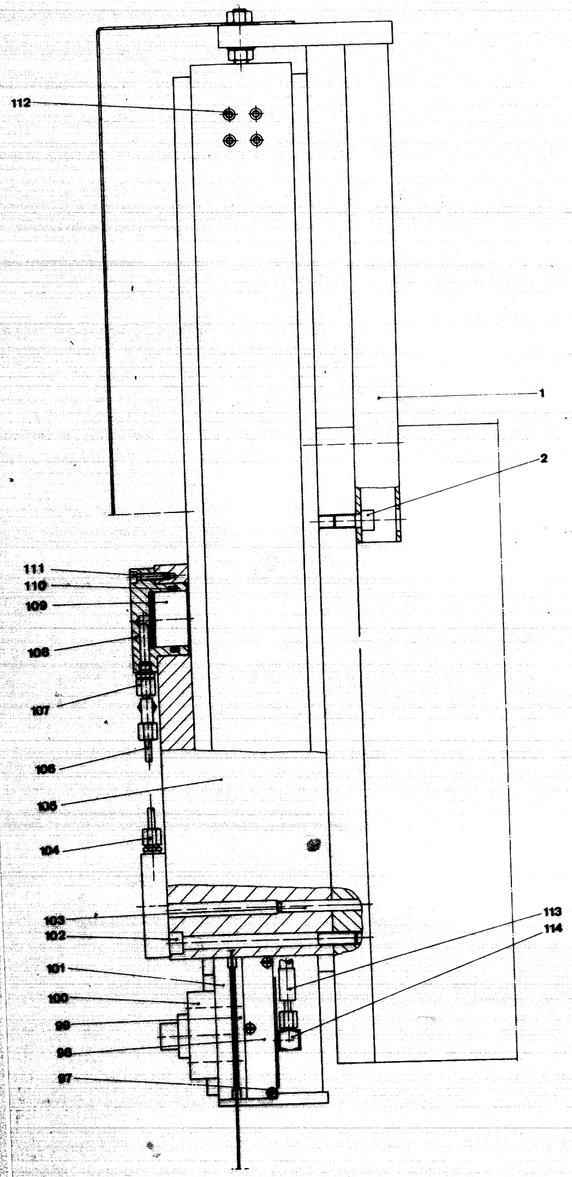
Zeichnung 2 von 9

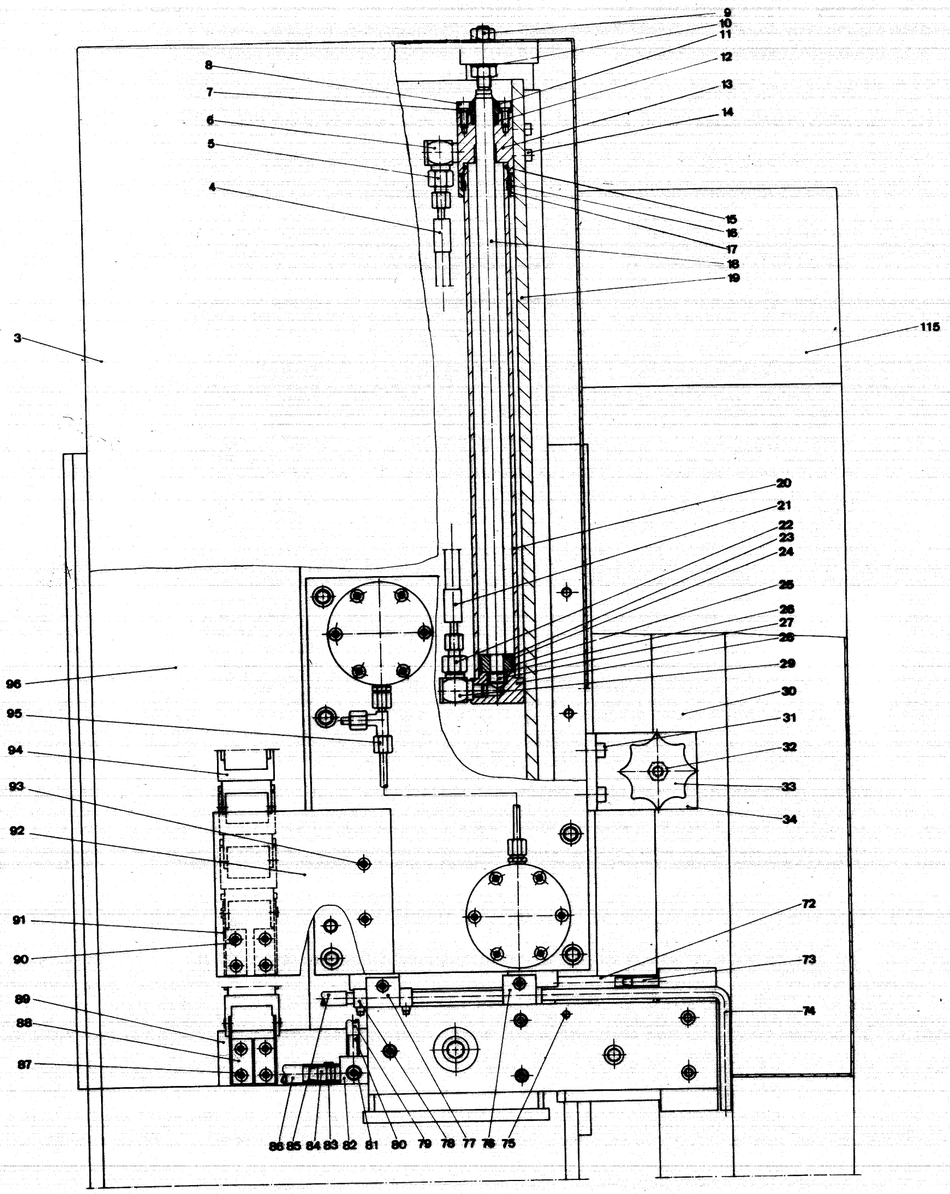
Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		Drawing 3 of 9	
1	Assy. Support	1	00844845
2	Allen screw M12x45-10.9 DIN 912	2	00071390
3	Protection cover	1	00844861
4	Hose pipe 2 TE 5 KOKO-1290	1	00368911
5	Cone-type reducing nozzle KO R 10/6 L	1	00328154
6	Throttle-free swivelling fitting		
	DSVW 10 LR	1	00074942
7	Cover	1	00279196
8	Allen screw M6x16-10.9 DIN 912	2	00070807
9	Hex nut M12 DIN 934 - 5 S	2	00072443
10	Washer	2	00227951
11	Scraper ring A1 16 x 24 x 7	1	00207373
12	Slotering Q3 YO 31060 16x24x7	1	00207365
13	Cylinder cover	1	00484032
14	Allen screw M6x30-10.9 DIN 912	4	00070858
15	O-Ring 35 x 2,5 N 78 80 shore	1	00207357
16	Clamping ring	1	00319872
17	Clamping piece	1	00319880
18	Piston rod	1	00758167
19	Assy. rail	1	00758205
20	Cylinder pipe	1	00758175
21	High pressure hose pipe		
	2 TE 5 KOKO 1400 LG	1	00755389
22	Cone-type reducing nozzle KO R 10/6 L	1	00328154
23	Piston	1	00395846
24	Cylinder seal set OH-701003Z		
	32 x 27,1 x 2,2	1	00396400
25	PDF-guide band F3 K130015		
	5,6 x 2,5 x 91	1	00351482
26	Washer B 8,4 - St DIN 125	1	00072613
27	Allen screw M8x16-10.9 DIN 912	1	00070963
28	Cylinder cover	1	00350796
29	Throttle-free swivelling fitting		
	DSVW 10 LR	1	00074942
30	Saw band	1	-
31	Allen screw M8x25-10.9 DIN 912	2	00070998

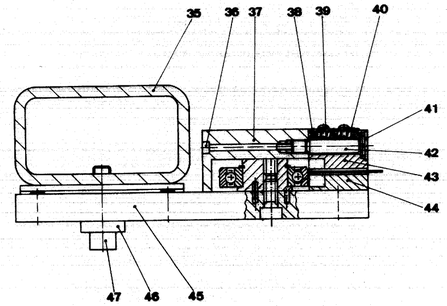
Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 3 of 9**	
32	Hex screw M10x30-8.8 DIN933	1	00070351
33	Star grip 70 DM x M 10	1	00024988
34	Angle	1	00758310
35	Assy. rail	1	00758205
36	Allen screw M6x 85-10.9 DIN 912	4	00282987
37	Support	1	00775487
38	Pressure spring 4,8x0,8x9,7x5,5if	12	00483982
39	Saucer head screw		
	M 6 x 8	8	00121029
40	Rail	4	00483990
41	Cover plate	2	00483737
42	Screw	4	00483753
43	Assy. guide	1	00775479
44	Assy. guide	1	00775428
45	Support plate	1	00775495
46	Washer B 17 - St DIN 7349	1	00391328
47	Allen screw M16x45-10.9 DIN 912	1	00209058
48	Assy. machine support	1	00951072
49	Hex screw M12x55-8.8 DIN933	4	00238120
50	Hose pipe	2	00286400
51	Angular screw-in-fitting	2	00326526
	WE 6 LR		
52	Connection piece	1	00223506
53	Allen screw M6x30-10.9 DIN 912	1	00070858
54	Throttle free swivelling fitting		
	DSVW 6 LR	1	00074802
55	Cap screw R 1/8"-5 S DIN906	2	00072230
56	Allen screw M12x30-10.9 DIN 912	2	00071366
57	Piston	2	00350133
58	Lip ring C2 N84 2010-20x12x5,5	2	00028339
59	Assy. guide	1	00775460
60	Assy. guide	1	00775436
61	Allen screw M8x30-10.9 DIN 912	4	00071005
62	Ball bearing 6208-2 RS	2	00295914
63	Snap ring A 40x1,75 DIN 471	2	00073938
64	Allen screw M12x30-10.9 DIN 912	2	00071366

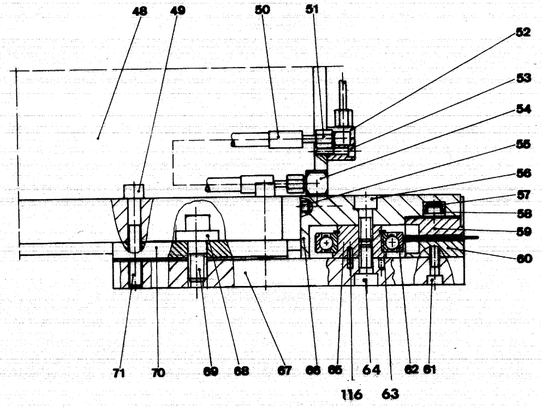
Nr.	Benennung	Stück	Bestellnummer
	Saw unit 01007017	**Drawing 3 of 9**	
65	Bearing bolt	2	00775509
66	Support	2	00775487
67	Support plate	1	00907065
68	Washer B 17 - St DIN 7349	1	00391328
69	Allen screw M1 6x45-10.9 DIN 912	1	00209058
70	Support	1	00907057
71	Threaded pin M12 x 25-12.9 DIN 913	6	00072141
72	Plastic hose, clear		
	D = 10x2WD 40.000	0,460	00325694
73	Hose fitting nozzle	2	00273732
74	Ermeto-pipe D=10x1,5 WD	1	00118834
75	Cylinder pin 6m6 x 30 DIN 6325	2	00238775
76	Clip	1	00094501
77	Clip	1	00094501
78	Hose clip	2	00022039
79	Plastic hose, clear		
	D = 10 x 2 WD 40.000	0,460	00325694
80	Hose fitting nozzle	2	00380032
81	Cap screw 1/4"	1	00072249
82	Distribution piece	1	00462330
83	Hose clip SGL 12-22/9 SKZ W1	1	00022039
84	Hose fitting nozzle	1	00025283
85	Plastic hose, green with thread		
	D = 13 x 2 WD 40.000	7,850	00141860
86	Plastic hose, green with thread		
	D = 13 x 2 WD 40.000	5,700	00141860
87	Allen screw M8x16-10.9 DIN 912	2	00070963
88	Connection piece (1 Pair)		
	200.2 with bolt	1	00370851
89	Support plate	1	00563579
90	Allen screw M8x16-10.9 DIN 912	2	00070963
91	Connection piece (1 Pair)		
	200.1 with bore	1	00370843
92	Support plate	1	00563560
93	Allen screw M6x16	4	00070807

Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 3 of 9**	
94	Cable drag chain		
	Nr. 25.3.055/24 GLD.1Treun	1	00633054
95	Fitting EVL 6 LR	1	00369098
96	Assy. machine support	1	00951072
97	Countersunk screw M4 x 10-8.8 DIN 7991		600595578
98	Cover plate	2	00483737
99	Assy. guide	1	00775460
100	Support plate	1	00907065
101	Assy. guide	1	00775479
102	Allen screw M12x160-10.9 DIN 912	8	00269190
103	Cylinder pin 12m6 x 70 DIN 6325	2	00304301
104	Straigth fitting		
	GE 6 LR	1	00074802
105	Guide housing	1	00252573
106	Fitting GE 6 LR	1	00074802
107	Fitting EVL 6 L	1	00331074
108	Cylinder cover	2	00254134
109	Piston	2	00254126
110	Slotering 50x60x7 NI 150	2	00329665
111	Allen screw M6x25-10.9 DIN 912	12	00070831
112	Allen screw M6x30-10.9 DIN 912	4	00070858
113	Hose pipe 2TE 5 KOKO 2950	1	01344870
114	Fitting GE 6 LR	1	00074802
115	Assy. cover plate	1	00563544
116	Parallel pin M6 x 30	1	00238775









BBS 560/1060
Serie 106

Sägeteil 01007017
Saw head
Tête de sciage

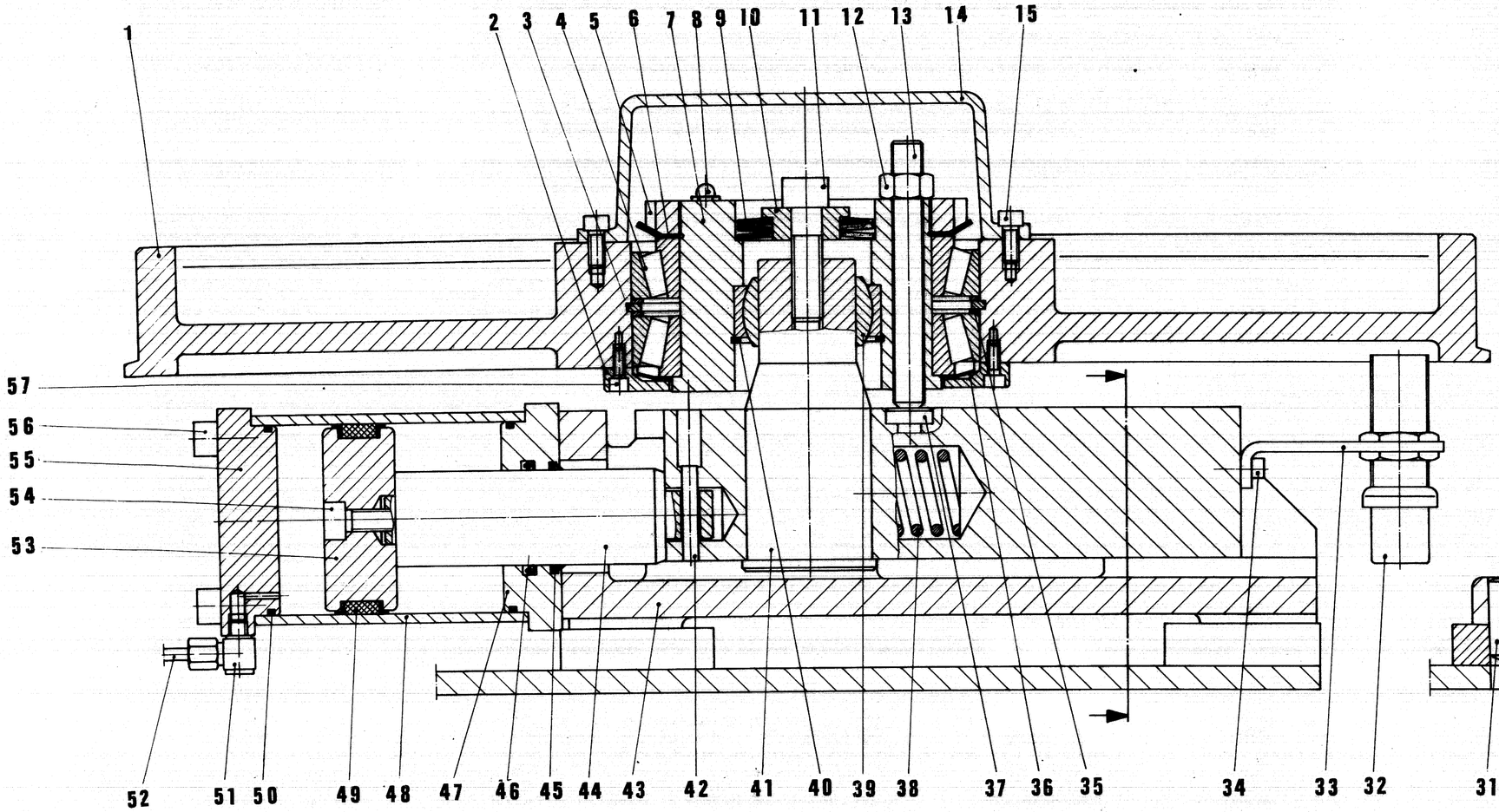
Zeichnung 3 von 9

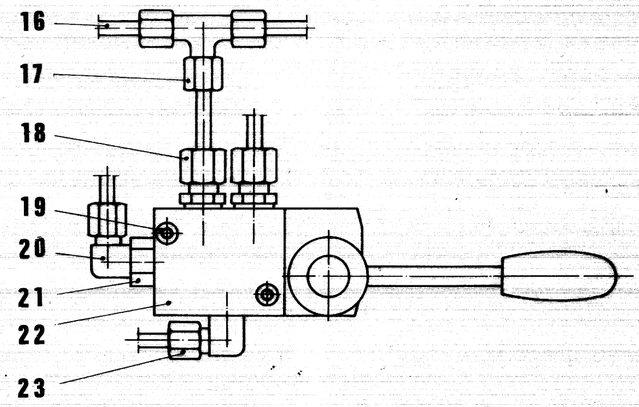
Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 4 of 9**	
1	Band wheel	1	00758191
2	Ring	1	00446114
3	Snap ring I 180 x 4 DIN 472	1	00446033
4	Taper roller bearing 32926	2	00446041
5	Shaft nut KM 26	1	00446092
6	Safety plate MB 26	1	00446084
7	Bearing bushing	1	00446076
8	Lubrication nipple R 1/8" DIN 3402	1	00023000
9	Plate spring 70 x 35,5 x 3,5 DIN2093	3	00026719
10	Pressure piece	1	00322334
11	Allen screw M16x60-10.9 DIN 912	1	00086657
12	Hex nut M 16 DIN 934-5 S	3	00072400
13	Threaded pin M16 x 140-12.9 DIN913	3	00446106
14	Cover	1	00446122
15	Allen screw M8x20-10.9 DIN 912	4	00070971
16	Pipe	1	00142964
17	Fitting T 6-L	1	00142913
18	Fitting GE 6 SR	2	00328146
19	Allen screw M6x50-10.9 DIN 912	2	00070890
20	Fitting WE 6-LR	1	00326526
21	Reducing nozzle	1	00292826
22	Directional valve	1	00325686
23	Fitting WE 6-LR	1	00326526
24	Allen screw M10x20-10.9 DIN 912	6	00071145
25	Rail	2	00359254
26	Taper pin 8x32-St DIN 7978	4	00411825
27	Allen screw M12x40-10.9 DIN 912	4	00071382
28	Saddle	1	00866512
29	Machine support	1	00951072
30	Support	1	00456837
31	Taper pin A12 x 36-St DIN 7978	2	00296953
32	Initiator	1	*
33	Angle	1	00379034
*	refer to General Drawing-Electrical Parts		

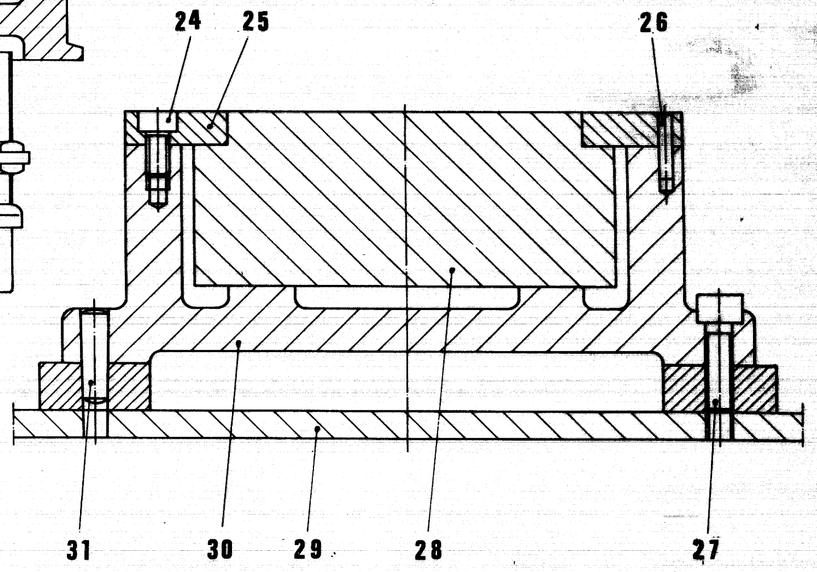
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Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		*Drawing 4 of 9*	
34	Allen screw M6x16-10.9 DIN 912	2	00070807
35	Distance ring	2	00758299
36	Nilos-Ring 32926 AV	2	00446068
37	Support bolt	2	00291137
38	Pressure spring 40 x 6,3 x 280 x 18,5	2	00445983
39	Swivel joint GE 50 ES	1	00357693
40	Snap ring I 75 DIN 472	1	00295051
41	Bearing bolt	1	00483877
42	Spring ping 8x50 DIN 1481	1	00211184
43	Support	1	00456837
44	Piston rod	1	00253987
45	Scraper ring P38 50 x 58 x 7	1	00028665
46	Slotering 50 x 60 x 7 NI 150	1	00329665
47	Cylinder cover	1	00253960
48	Cylinder	1	00253979
49	Piston seal	1	00329983
50	O-Ring 94 x 3 N 78 80 shore	2	00215635
51	Fitting GE 6 LR	1	00074802
52	Pipe	1	00142964
53	Piston	1	00253995
54	Allen screw M12x35-10.9 DIN 912	1	00071374
55	Cylinder cover	1	00254002
56	Allen screw M12x200-10.9 DIN 912	4	00274984
57	Allen screw M6x16-10.9 DIN 912	4	00070807







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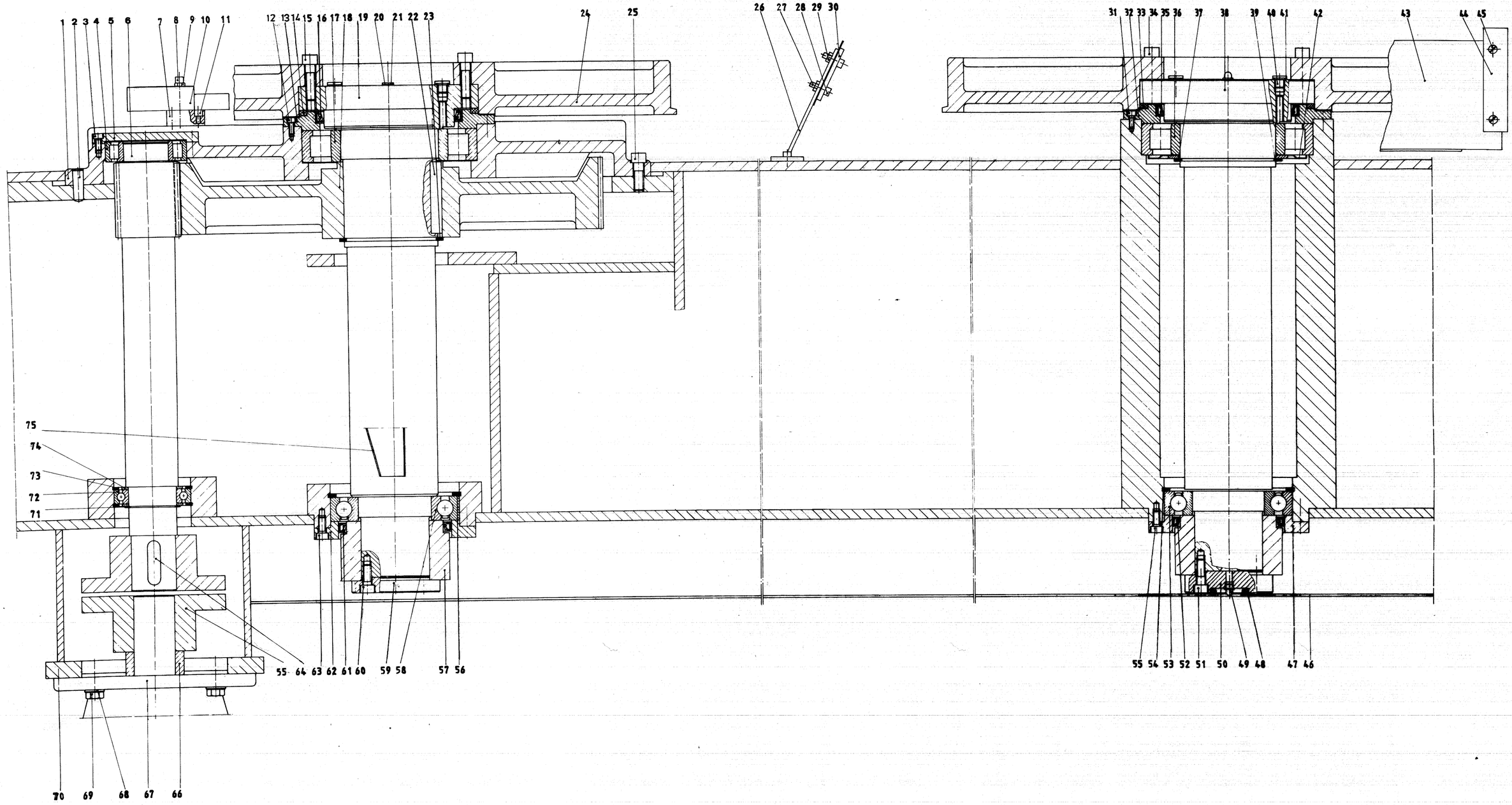
Sägeteil 001007017
Saw head
Tête de sciage

Zeichnung 4 von9

Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		Drawing 5 of 9	
1	Gear cover	1	00633232
2	Parallel pin 10m6x40 DIN 6325	2	00073717
3	Allen screw M6x20-10.9 DIN 912	8	00070823
4	Cylinder roller bearing NJ 2211	1	00736724
5	Cover	1	00736813
6	Pinion shaft		
	(depending on cutting speed)	1	-
7	Holder	1	00759449
8	Allen screw M6x45-10.9 DIN 912	1	00070882
9	Hex nut M 6 DIN 934 - 5 S	1	00072389
10	Assy. band tensioning lever	1	00474185
11	Allen screw M6x60-10.9 DIN 912	1	00070912
12	Allen screw M6x20-10.9 DIN 912	4	00070823
13	Flange	1	00721379
14	Felt ring	1	00633178
15	Allen screw M12x45-10.9 DIN 912	12	00071390
16	Ring B 21 60 x 180 x 15	1	00329657
17	Cylinder roller bearing NU 224 E	1	00736694
18	Gear	1	00721387
19	Bearing shaft	1	00758213
20	Copper ring 10 x 14 x 1 DIN 7603 A	1	00026182
21	Cap screw R 1/8" - 5 S	1	00328022
22	Key A 25 x 14 x 90 DIN 6885	1	00087122
23	Snap ring 115 x 4,0 DIN 471	1	00736651
24	Band wheel	2	00775371
25	Allen screw M12x40-10.9 DIN 912	16	00071382
26	Assy. holder	2	00761796
27	Hex nut M6 DIN 934 - 5 S	4	00072389
28	Allen screw M6x20-10.9 DIN 912	8	00070823
29	Scraper	2	00761753
30	Rail	2	00761761
31	Allen screw M12x40-10.9 DIN 912	16	00071382
32	Flange	1	00721379
33	Felt ring	1	00633178
34	Allen screw M12x45-10.9 DIN 912	12	00071390
35	Ring B2 160 x 180 x 15	1	00329657

Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		Drawing 5 of 9	
36	Cylinder roller bearing NU 224 E	1	00736694
37	Washer SS 120x150x35 DIN 988	1	00736759
38	Bearing shaft	1	00758221
39	Snap ring A 120x4,0 DIN 471	1	00322377
40	Cap screw R 1/4"-5 S DIN 908	4	00372048
41	Copper ring 13,5 x 18 x 1,5 DIN 7603A	4	00131091
42	Nilos-Ring	1	00736732
43	Assy. Cover plate	1	00669784
44	Rail	1	01312367
45	Countersunk screw M6x8-8.8 DIN 7991	2	00604860
46	Cover plate	1	00483362
47	Cover	1	00736805
48	O-Ring 32x8,0 N 78 80 shore	1	00669075
49	Lubrication nipple H1 R 1/8" DIN 3402		200023000
50	Cover	1	00669040
51	Allen screw M10x35-10.9 DIN 912	4	00071188
52	Ring B 120 x 140 x 13	1	00483907
53	Needle roller bearing 6218-Z	1	00736716
54	Snap ring I 160 DIN 472	1	00086436
55	Allen screw M8x20-10.9 DIN 912	6	00070971
56	Snap ring I 160 DIN 472	1	00086436
57	Distance ring	2	00866814
58	Needle roller bearing 6218 - Z	1	00736716
59	Cover	1	00475130
60	Allen screw M10x30-10.9 DIN 912	4	00071161
61	Ring B 2 120x140x13	1	00483907
62	Cover	1	00736805
63	Allen screw M8x20-10.9 DIN 912	6	00070971
64	Key 16x10x50 DIN 6885		
	(depending on cutting speed)	1	-
65	Rupex clutch (Flender) Rewn 162		
	(depending on cutting speed)	1	-
66	Distance bushing		
	(depending on cutting speed)	1	-
*	refer to General Drawing - Electrical Parts		

Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 5 of 9**	
67	Gear motor	1	*
68	Washer 13 DIN 125 - St	4	00072648
69	Hex screw M12x35-8.8 DIN 933	4	00086800
70	Assy. machine support	1	00951072
71	Snap ring A 60 x 2,0 DIN 471	1	00073954
72	Needle roller bearing 6012 2 RS	1	00867586
73	Snap ring J 95 N 472	2	00074098
74	Washer SS 60 x 75 x 3 DIN988	2	00342378
75	Assy. trough	1	00517488



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Sägeteil 01007017
Saw head
Tête de sciage

Zeichnung 5 von 9

Nr.	Benennung	Stück	Bestellnummer
	Saw unit 01007017	**Drawing 6 of 9**	
1	Roller chain 5/8"x3/8"		
	233 links DIN 8187	1	00559334
	Chain joint 2E 5/8"x3/8" DIN 8187	1	00268283
2	Assy. cable duct	1	00844292
3	Assy. machine support	1	00951072
4	Gear motor	1	*
5	Allen screw M12x30-10.9 DIN 912	4	00071366
6	Double sprocket	1	00475300
7	Snap ring 47 x 1,75 DIN 472	1	00074004
8	Bearing bolt	1	00475289
9	Snap ring A 25 x 1,2 DIN 471	1	00073873
10	Needle roller bearing 60 05 Z	2	00023914
11	Allen screw M12x35-10.9 DIN 912	1	00071374
12	Spring disk	1	00869465
13	Distance ring	1	00563099
14	Double sprocket	1	00475262
15	Band tensioning lever	2	00560626
16	Snap ring A 35 x 1,5 DIN 471	2	00073911
17	Snap ring I 80 DIN 472	4	00074063
18	Needle roller bearing 6307 2 RS	4	00372382
19	Eccentric bolt	2	00560618
20	Roller track 305807	2	00199648
21	Snap ring A 35 x 1,5 DIN 471	2	00073911
22	Hex nut M 20 DIN 936	2	00072508
23	Washer B 21-St DIN 125	2	00072664
24	Snap ring A 25 x 1,2 DIN 471	2	00073873
25	Taper pin A10 x 32-St DIN 7978	2	00381381
26	Allen screw M12x50-10.9 DIN 912	4	00071404
27	Bearing bolt	2	00475351
28	Snap ring A 30 x 1,5 DIN 471	2	00073903
29	Roller track 305806	2	00108413
30	Support	2	00844896
31	Snap ring A 30 x 1,5 DIN 471	2	00073903

* refer to Genearal Drawing - Electrical Parts

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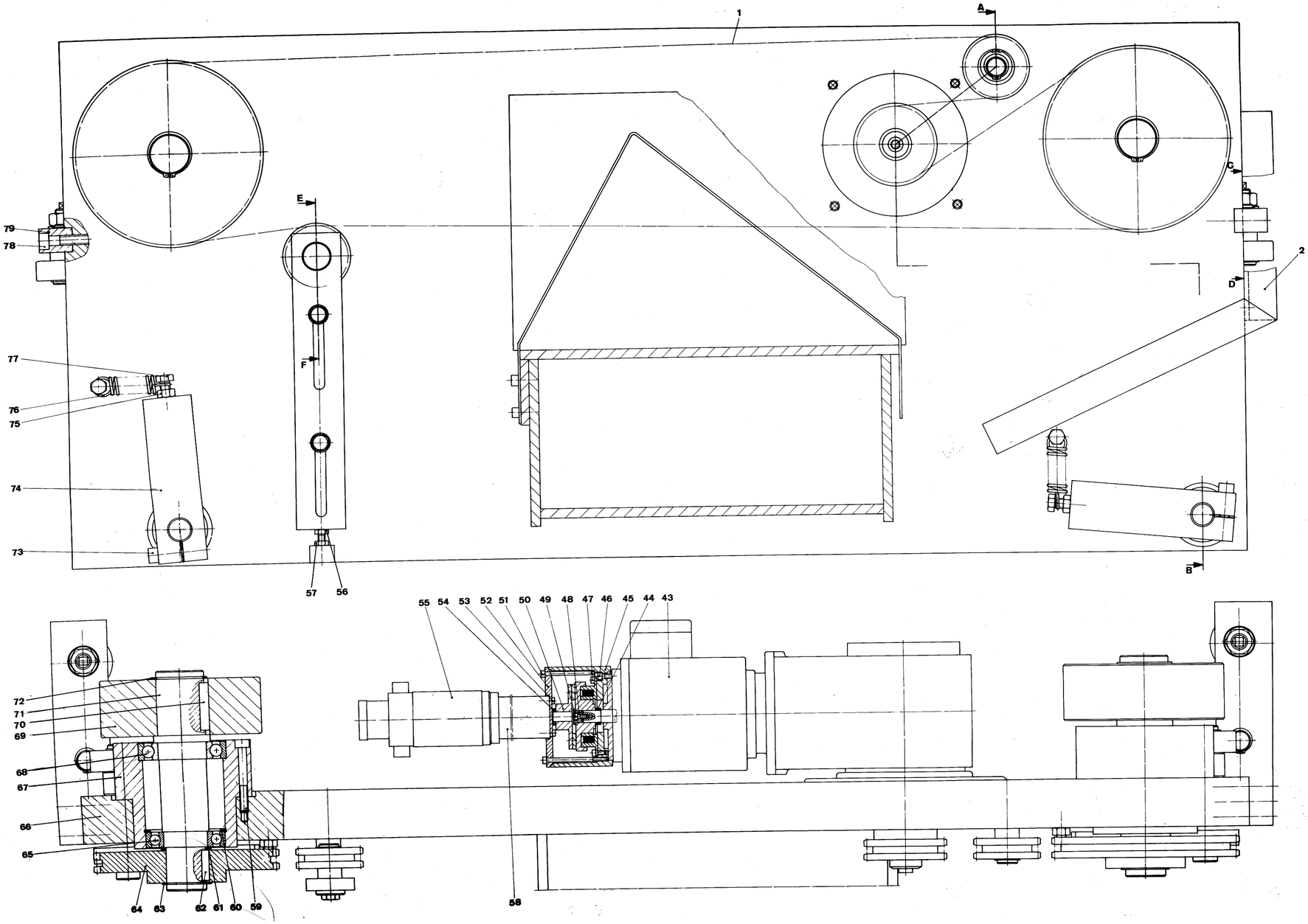
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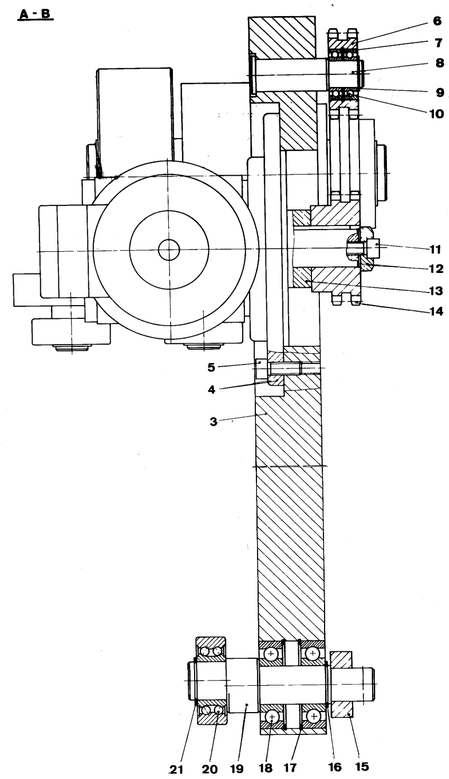
Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 6 of 9**	
32	Eccentric bolt	2	00475343
33	Roller track 305806	2	00108413
34	Bolt	2	00483419
35	Hex screw M12x40-8.8 DIN931	2	00378399
36	Washer 13-St DIN 7349	2	00183865
37	Rail	1	00483478
38	Bearing bolt	1	00483427
39	Needle roller bearing 6005-Z	2	00023914
40	Snap ring 47 x 1,5 DIN 472	1	00074004
41	Double sprocket	1	00475300
42	Snap ring A 25 x 1,2 DIN 471	1	00073873
43	Gear motor	1	*
44	Distance piece	1	00868833
45	Support	1	00866628
46	Allen screw M6x16-10.9 DIN 912	3	00070807
47	Allen screw M5x12-10.9 DIN 912	4	00070645
48	Washer	1	00760110
49	Allen screw M5x12-10.9 DIN 912	1	00070645
50	Clutch	1	*
51	Allen screw M5x75-10.9 DIN 912	4	00712531
52	Cover	1	00866601
53	Allen screw M5x12-10.9 DIN 912	4	01344285
54	Washer	1	00866571
55	Gear motor	1	*
56	Hex screw M10x90-8.8 DIN933	1	00591343
57	Hex nut M 10 DIN 934 - 5 S	1	00072435
58	Gear motor	1	*
59	Allen screw M10x80-10.9 DIN 912	12	00071285
60	Snap ring I 100 DIN 472	2	00086428
61	Washer SS 50 x 62 x 3 DIN 988	2	00292117
62	Key 14 x 9 x 40 DIN 6885	2	00430307
63	Snap ring A 50 x2,0 DIN 471	2	00073946
64	Double sprocket	2	00475327
65	Needle roller bearing 6211-Z	2	00308811
*	refer to General Drawing -Electrical Parts		

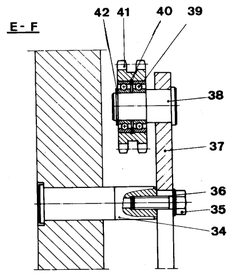
Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 6 of 9**	
66	Assy. machine support	1	00951072
67	Bushing	2	00483494
68	Needle roller bearing 6212- Z	2	00247375
69	Roller track	2	00475297
70	Key A 18 x 11 x 6 DIN 6885	2	00248819
71	Bearing shaft	2	00475246
72	Snap ring 60 x 2,0 DIN 471	2	00073954
73	Allen screw M12x50-10.9 DIN 912	2	00071404
74	Band tensioning lever	2	00560626
75	Hex nut M 12 DIN 934 - 5 S	4	00072443
76	Spring 25 x 3,6 x 89,7 Z-177 M	2	00365483
77	Hex screw M12x40-8.8 DIN933	4	00868819
78	Allen screw M12x50-10.9 DIN 912	4	00071404
79	Support	2	00844896

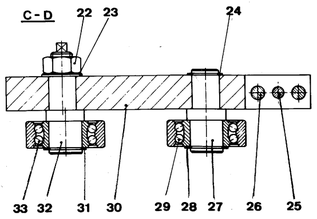
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BBS 560/1060
ab Serie 106

Sägeteil 01007017
Saw head
Tête de sciage

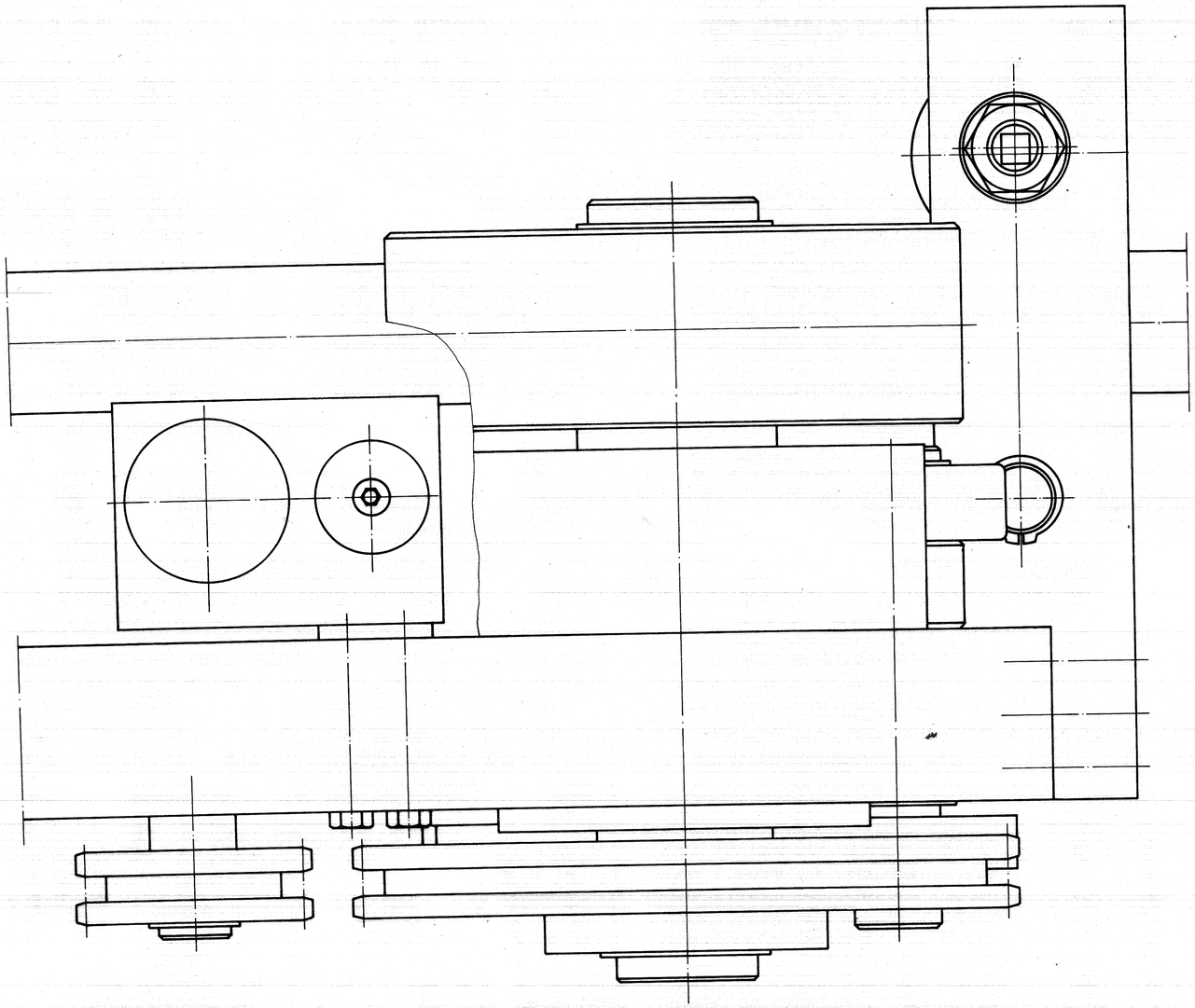
Zeichnung 6 von 9

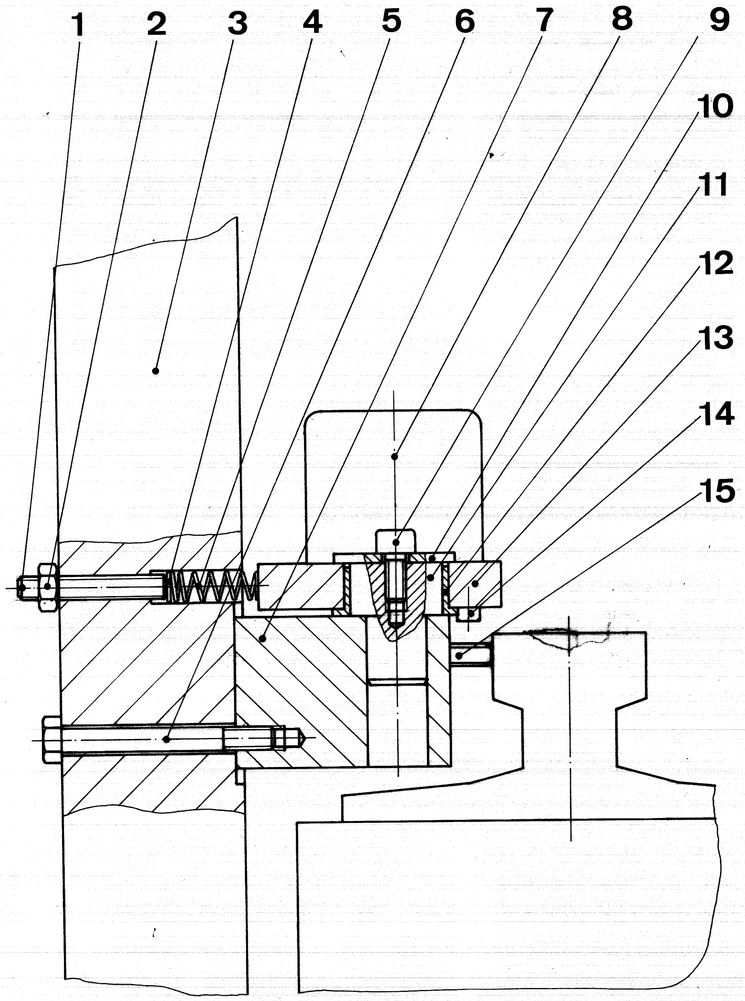
Nr.	Benennung	Stück	Bestellnummer
	Saw unit 01007017	**Drawing 7 of 9**	
1	Threaded pin M8x45-12.9 DIN 913	1	00292028
2	Hex nut M 8 DIN 934-5 S	1	00072427
3	Machinen support	1	00951072
4	Washer B 5,3 - St DIN 125	1	00072591
5	Pressure spring 9 x 1 x 52 x 13,5	1	00196517
6	Hex screw M8x70-8.8 DIN 933	2	00362654
7	Holder	1	00761141
8	Encoder	1	*
9	Allen screw M8x16-10.9 DIN 912	1	00070963
10	Washer	1	00326682
11	Bolt	1	00760250
12	DU-bushing 30/34 x 16	1	00321028
13	Support	1	00761168
14	Allen screw M4x12-10.9 DIN 912	3	00084441
15	Roller track	1	00559415

* refer to General Drawing - Electrical Parts

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Sägeteil 01007017
Saw head
Tête de sciage

Zeichnung 7 von 9

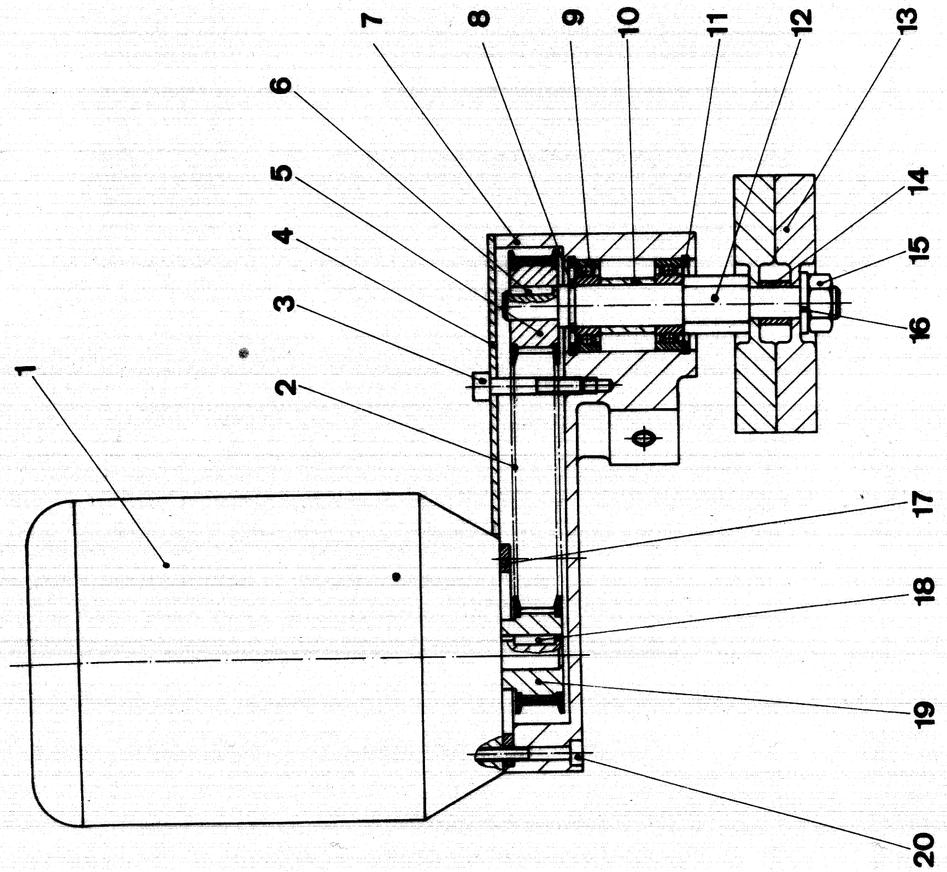
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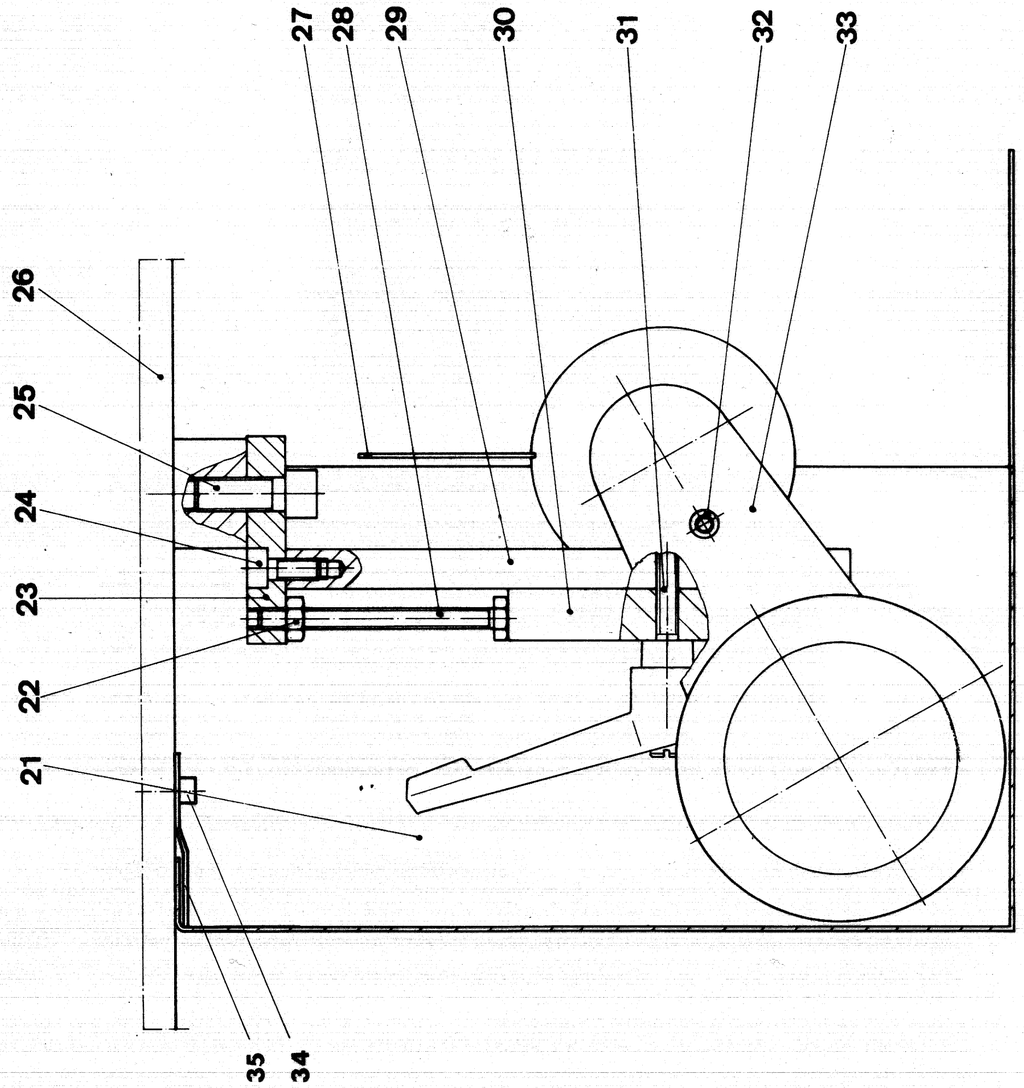
Nr.	Benennung	Stück	Bestellnummer
	Saw unit 01007017	**Drawing 8 of 9**	
1	Motor	1	*
2	Toothed belt 150 L050	1	00364657
3	Allen screw M6x35-10.9 DIN 912	1	00070866
4	Cover plate	1	00371556
5	Gear 12 L050 Type 10AF	1	00364622
6	Key 4 x 4 x 16 DIN 6885	1	00364606
7	Housing	1	00371505
8	Snap ring 17 x 1,0 DIN 471	1	00097454
9	Needle roller bearing 6003 RS	2	00326666
10	Distance bushing	1	00373001
11	Snap ring 35 x 1,5 DIN 472	2	00073989
12	Bearing bolt	1	00371521
13	Alpha-Chip removal brush		
	D = 100 Typ AS 3101	2	00332577
14	Distance bushing	1	01028138
15	Hex nut M 12 DIN 934 - 5S	1	00072443
16	Washer B 13 - St DIN 125	1	00072648
17	Distance ring	1	00371513
18	Key 4 x 4 x 16 DIN 6885	1	00364606
19	Gear 3/8" 10 L050	1	00364614
20	Allen screw M 5 x 35	4	00070718
21	Assy. proctection plate	1	00563048
22	Hex nut M8x90-8.8 DIN 933	1	00072427
23	Plate	1	00517453
24	Allen screw M8x20-10.9 DIN 912	2	00070971
25	Allen screw M 12 x 35	1	00071374
26	Machine support	1	00951072
27	Saw band	1	-
28	Hex screw M8x90-8.8 DIN933	1	00070335
29	Rail	1	00517437
30	Rail	1	00517461
31	Band tensioning lever M 8 x 40 Gr.2	2	00685178
32	Allen screw M6x35-10.9 DIN 912	1	00070866
33	Cover plate	1	00371556
*	refer to General Drawing - Electrical Parts		

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Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 8 of 9**	
34	Allen screw M6x12-10.9 DIN912	2	00070785
35	Holder	1	00668532





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Sägeteil 01007017
Saw head
Tête de sciage

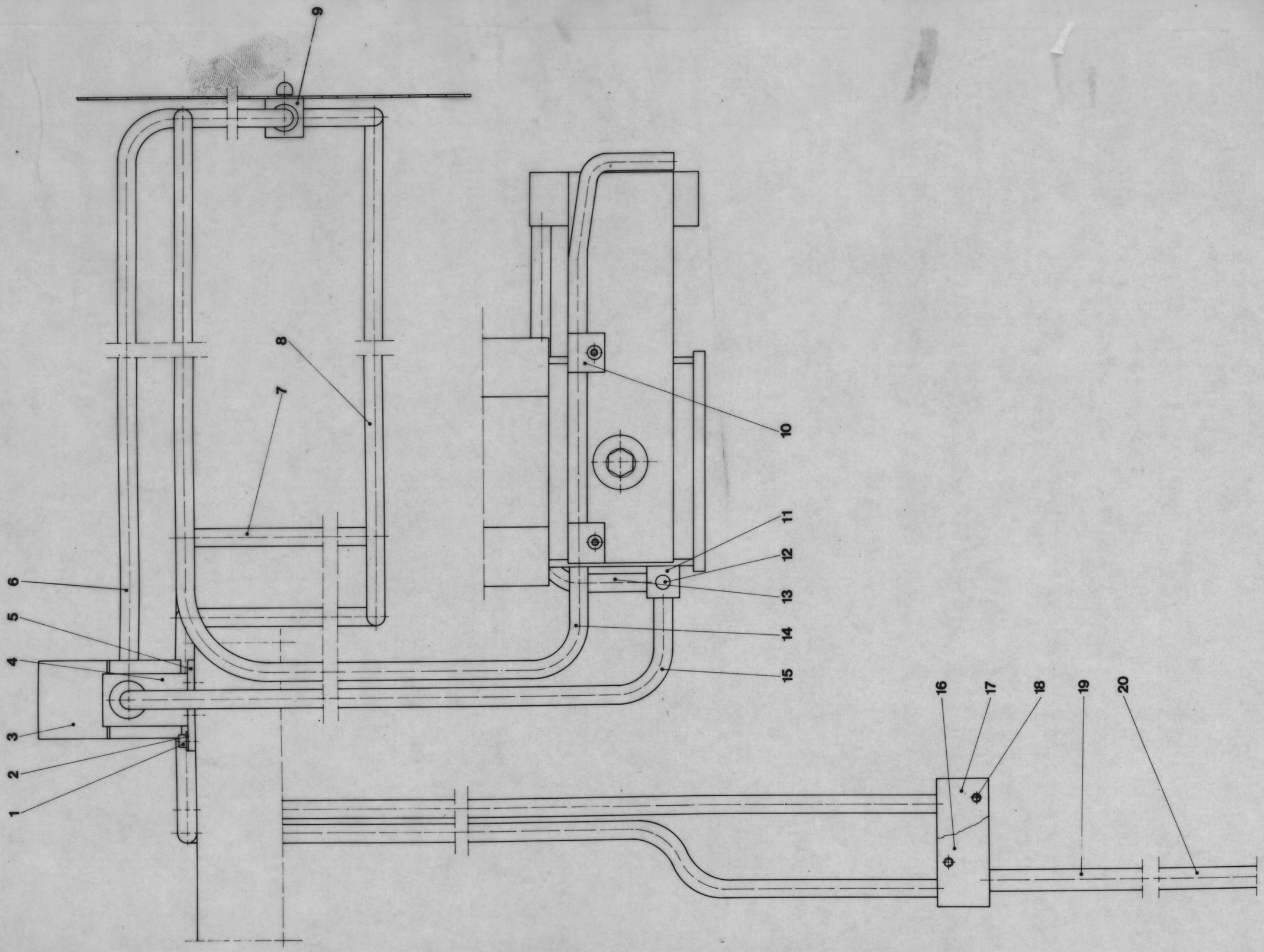
Zeichnung 8 von 9

Nr.	Benennung	Stück	Bestellnummer
Saw unit 01007017		**Drawing 9 of 9**	
1	Allen screw M6x12-10.9 DIN 912	2	00070785
2	Washer B 6,4-St DIN 125	2	00135879
3	Flow control	1	*
4	Holder	2	01440144
5	Plate	1	01440136
6	Plastic hose green with thread		
	D = 13x3 WD 40.000	2,100	00141860
7	Plastic hose green with thread		
	D = 13x3 WD 40.000	0,450	00141860
8	Plastic hose green with thread		
	D = 13x3 WD 40.000	0,550	00141860
9	Ball fitting R1/4" Type 3410	2	00025372
10	Clip	2	00094501
11	Distribution piece	1	00462330
12	Cap screw R 1/4"-5 S DIN906	1	00072249
13	Plastic hose, clear		
	D = 10x2 WD 40.000	0,460	00325694
14	Plastic hose, green with thread		
	D = 13x3 WD 40.000	7,850	00141860
15	Plastic hose, green with thread		
	D = 13x3 WD 40.000	5,700	00141860
16	Rail	1	00950014
17	Holder	1	00253723
18	Hex screw M6x40-8.8 DIN933	2	00070254
	Washer B 6,4-St DIN 125	2	00072605
	Hex nut M6 DIN 934 8 Verz.	2	00370304
19	Plastic hose green		
	D = 16x4 WD 40.000	2,200	00491225
20	Plastic hose green		
	D = 16x4 WD 40.000	8,340	00491225
	Cutting length 3000		
	Plastic hose green		
	D = 16 x 4 WD 40.000	8,800	00491225
	Cutting length 4000		
*	refer to General Drawing - Electrical Parts		

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Nr.	Benennung	Stück	Bestellnummer
	Saw unit 01007017	**Drawing 9 of 9**	
	Plastic hose green		
	D = 16 x 4 WD 40.000	9,260	00491225
	Cutting length 5000		
	Plastic hose green		
	D = 16 x 4 WD 40.000	9,720	00491225
	Cutting length 6000		
	Plastic hose green		
	D = 16 x 4 WD 40.000	10,720	00491225
	Cutting length 7000		
	Plastic hose green		
	D = 16 x 4 WD 40.000	10,870	00491225
	Cutting length 8000		



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Ersatzteile 01007017
Spare parts
Pieces de rechange

Zeichnung 9 von 9
Drawing 9 of 9
Dessin 9 a 9

Nr.	Benennung	Stück	Bestellnummer
	Table assembly CL 6000 00951528 Drawing 1 of 1		
	Table assembly CL 6100 01559540		
1	Calvanized chain x = 36	2	01460900
	Calvanized chain x = 17	2	01460846
	Calvanized chain x = 51	2	01460870
	Calvanized chain x = 38	2	01460889
	Calvanized chain x = 35	10	01460897
2	Assy. pipe	3	01460838
3	Assy. railing	1	00869783
4	Calvanized snap hook 80mm	36	00685623
5	Angle	2	01006460
6	Holder	2	01544527
7	Steps 600x240DIN24531	7	00709425
8	Hex screw M12x45 DIN 931-8.8	28	00070157
9	Washer 13-St DIN 7349	28	00183865
10	Assy. Table	1	00844314
11	Hex nut M 16 DIN 934-8	7	00072400
12	Assy. rail CL 6000	1	00774650
	Assy. rail CL 6100	1	01559516
13	Assy. safety guard	1	00950602
14	Assy. protective plate	1	00844640
15	Grating 1000x400x20	1	00687243
16	Assy. holder	7	00844667
17	Assy. support	1	00950750
	Assy. support	1	00950769
18	Cable drag chain Nr.20.4.055 80links	1	00921815
19	Trough (2150 long)	1	00844934
	Trough (2000 long)	2	00844950
	Trough (1350 long)	1	00844942
20	Assy. rail CL 6000	1	00844497
	Assy. rail CL 6100	1	01559494
21	Hex nut M16 x 1,5 DIN934 - M8	14	00297690
22	Hex screw M16x1,5x70 DIN 961	14	00617253
23	Trough	1	00758086
24	Bushing	4	00516392
25	Spindle nut	2	00568813

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Nr.	Benennung	Stück	Bestellnummer
Table assembly CL 6000	**00951528**	**Drawing 1 of 1**	
Table assembly CL 6100	**01559540**		
26	Distance piece	4	00761958
	Laminium-ring		
	D = 68, D = 47, H = 1, S = 0,05	4	00867446
27	Set screw	4	00568791
28	Assy. table CL 6000	1	00951404
	Assy. table CL 6100	1	01559524
29	Rail	12	01314602
30	Assy. pipe	7	01460811
31	Grating 1000x470x30	12	00920096
	Grating 800x600x30	1	00485470
32	Rail	25	00907073
33	Rail	1	00907138
34	Rail	24	00907103
35	Assy. protective plate	2	00844691
	Assy. protective plate	1	00844721
36	Assy. protective plate CL 6000	1	00844748
	Assy. protective plate CL 6100	1	01559486
37	Assy. protective plate	1	00844764
	Cellular cooutchouc sealing strip		
	black, 15 x 5	6,150	00355542
38	Grating 1400x470x30	12	00866547
39	Hex screw M10x25 DIN933-8.8	32	00070343
40	Hex nut M10 DIN 934 - 8	32	00072435
41	Angle	2	00868736
42	Rail	2	00868701

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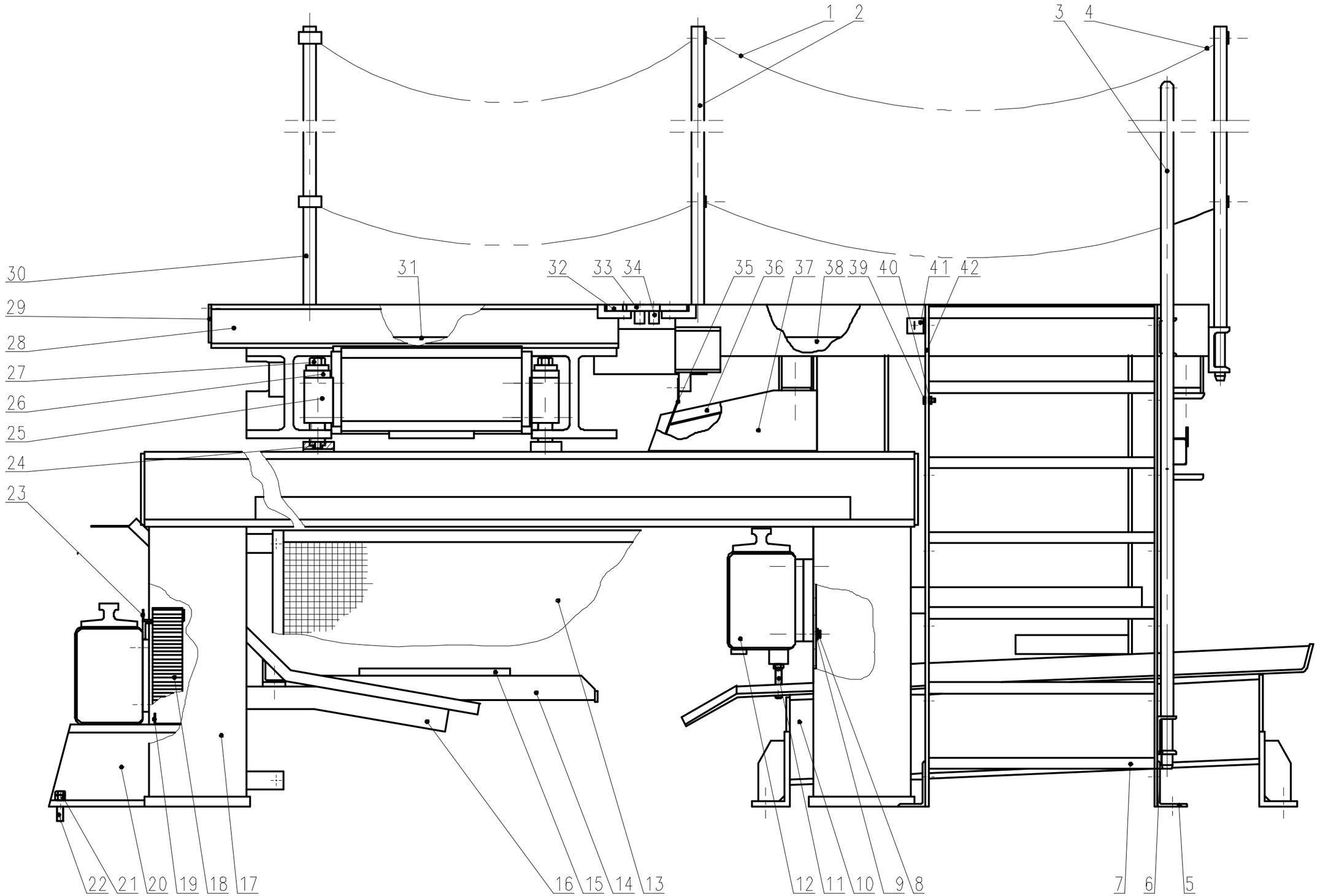
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ERSATZTEILE
SPARE PARTS
PIECES DE RECHANGE

TISCHGRUPPE
TABLE ANSSEMBLY
ENSEMBLE TABLE

00951501, 00951528, 00951536, 00951552, 01314866,
01559540, 02141760, 02203936, 02299038, 03104265,
03114848, 03214680



Mat.-Nr. 00951552 3 000501
Datum: 21.05.1990 Name: PUSCH

Nr.	Benennung	Stück	Bestellnummer
Chip conveyor 01344579		**Drawing 1 of 1**	
1	Suction basket	1	00144908
	Distance ring	1	01470493
2	Coolant pump	1	*
3	Cover plate	1	01021907
4	Saucer head screw		
	M 6 x 8	21	00121029
5	Protective plate	1	01021915
6	Protective plate	1	01021893
7	Hex screw M8x35-8.8 DIN 933	32	00070300
	Washer 8,4 - ST DIN 7349	32	00366323
	Hex nut M 8 DIN 980	32	00326674
8	Assy. chip scraper	16	00871028
9	Rail	32	00871109
10	Hex nut M 8 DIN 980-8	32	00326674
11	Angle	2	01007351
12	Hex nut M 16 DIN 934 - 5S	4	00072400
	Washer 17 - ST DIN 7349	4	00391328
13	Hex screw M16x160-8.8 DIN 933	2	00561991
	Washer 17 - ST DIN 7349	2	00391328
14	Key 8 x 7 x 56 DIN 6885	1	00625264
15	Worm facewidth SA 40 DT 71 D8	1	*
16	Threaded pin M 12 x 30 - 12.9 DIN 913	2	00144207
17	Snap ring A 25 x 1,2 DIN 471	1	00073873
18	Hex nut M 12 DIN 934 - 5S	2	00072443
19	Sprocket	2	00871125
20	Key A 8 x 7 x 30 DIN 6885	2	00235709
21	Snap ring A 26	3	00529087
22	Motor shaft	1	00871036
23	Allen screw M8 x 12-10.9 DIN 912	6	00134120
	Washer B 8,4 - ST DIN 125	6	00072613
24	Y-Flange bearing PF 20 FM 52 - 25 FJ	2	00792608
25	Roller chain 1 1/2"x1/2" 455 links	2	01344668
	Nr. RL 788 ANSI 2062		
26	Bearing shaft	1	00871044
*	refer to General Drawing - Electrical Parts		

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Nr.	Benennung	Stück	Bestellnummer
	Chip conveyor 01344579	**Drawing 1 of 1**	
27	Snap ring 40 x 1,75 DIN 472	2	00073997
28	Snap ring 17 x 1,0 DIN 471	2	00097454
29	Needle roller bearing 6203 - 2RS	4	00485233
30	Sprocket	2	00871133
31	Assy. chip conveyor	1	00952230

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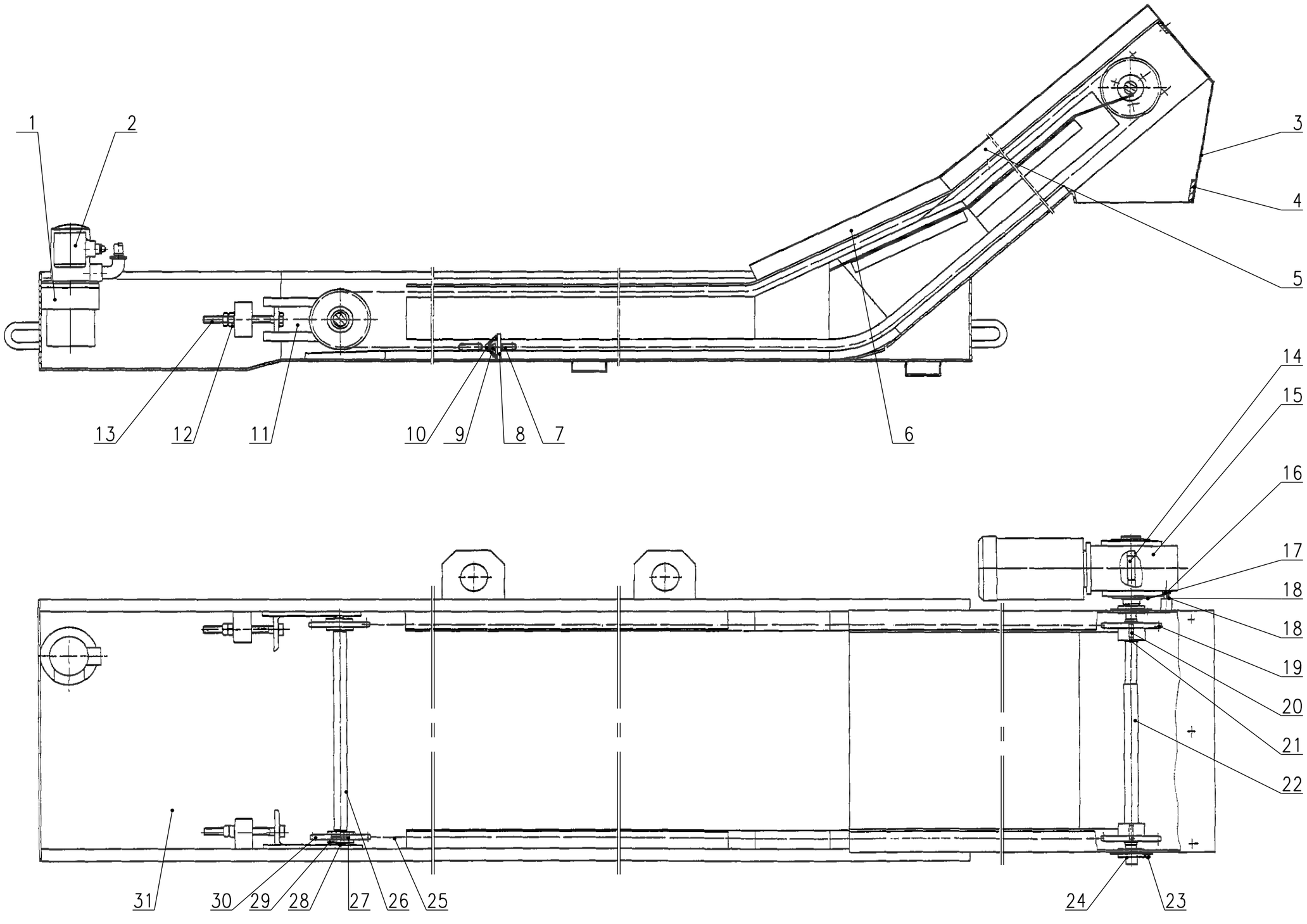
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ERSATZTEILZEICHNUNG
SPARE PARTS
PIECES DE RECHANGE

SONDERZUBEHÖR:	SPÄNEFÖRDERER	00995460, 01341367, 01344552, 01344560, 01344579,
OPTION:	CHIP CONVEYOR	01344587, 01344595, 01345214, 01345222, 01414142,
OPTION:	EVACUATEUR DE COPEAUX	01438565, 01559966, 02141787, 02650304, 03215180

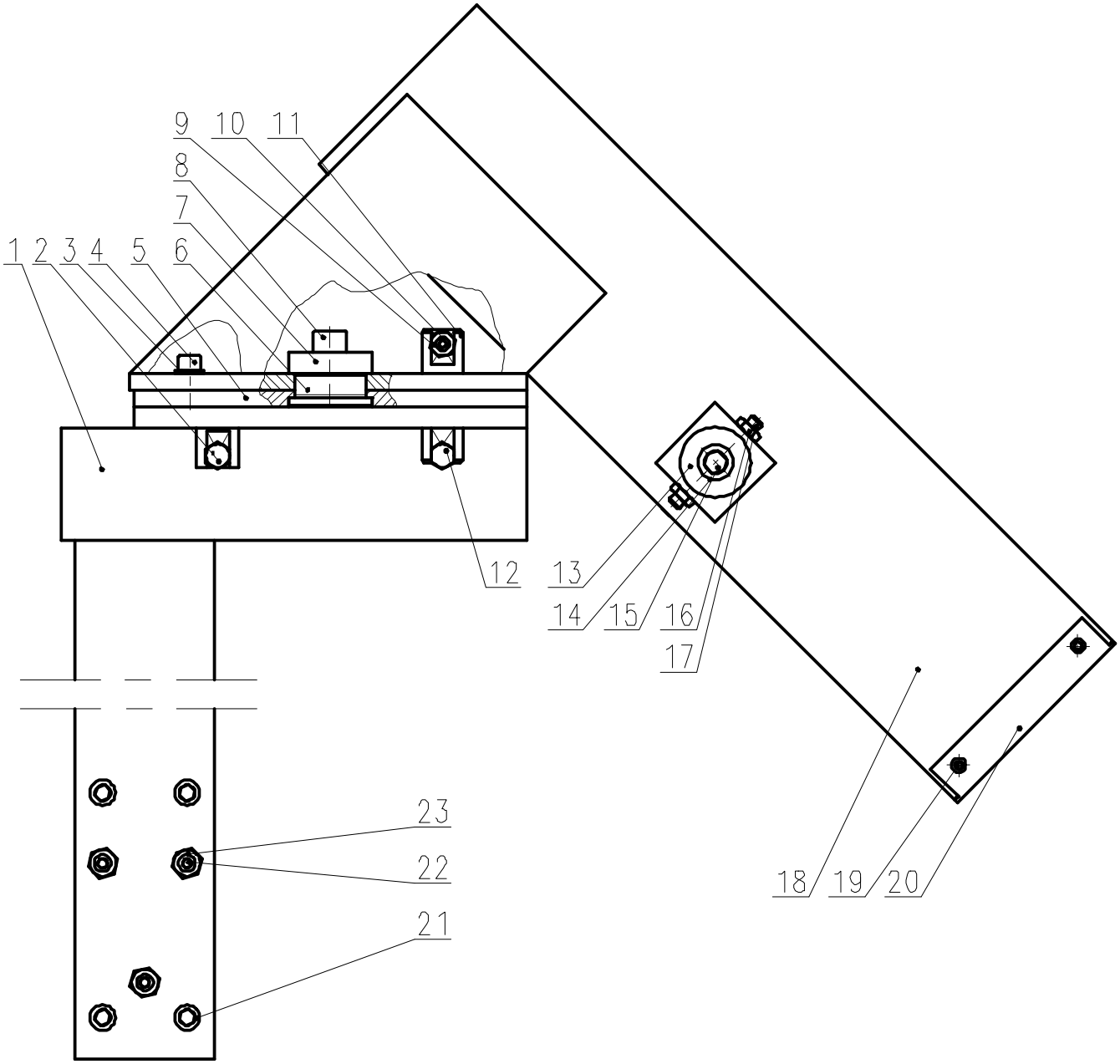


Mat.-Nr.: 01344595 3 000501
Datum: 16.02.1995 Name: M.PUSCH

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Laser lamp 01470973	**Drawing 1 of 1**	
1	Assy. holder	1	01523228
2	Hex screw 10x50 DIN 933-8.8	2	00070394
	Hex nut M 10 DIN 936 - 17 H	2	00082260
3	Washer B 10,5-St DIN 125	5	00072621
4	Allen screw M 10x25-10.9 DIN 912	5	00071153
5	Assy. plate	1	01460803
6	Washer	1	01440497
7	Allen screw M 16x35-10.9 DIN 912	1	00347663
8	Hex nut M 10 DIN 936 - 17 H	2	00082260
9	Threaded pin M 10x60 DIN 913	2	00304840
10	Hex nut M 10 DIN 936 - 17 H	2	00082260
11	Washer	1	01440500
12	Bolt	1	01440446
13	Allen screw M 16x35-10.9 DIN 912	1	00347663
14	Hex nut M 10 DIN 936 - 17 H	2	00082260
15	Threaded pin M 10x30 DIN 913	2	00200115
16	Assy. support	1	01440527
17	Saucer head screw		
	M 6 x 6	4	00438294
18	Cover	1	00950459
19	Allen screw M 12x40-10.9 DIN 912	4	00071382
20	Threaded pin M 12x30 DIN 913	3	00144207
21	Hex nut M 12 DIN 936- 17 H	3	00326704
	Magnet Nr. 106007	4	00396516

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Mat.-Nr.: 01470973 4 000501
Datum: 16.05.1990 Name: PUSCH M

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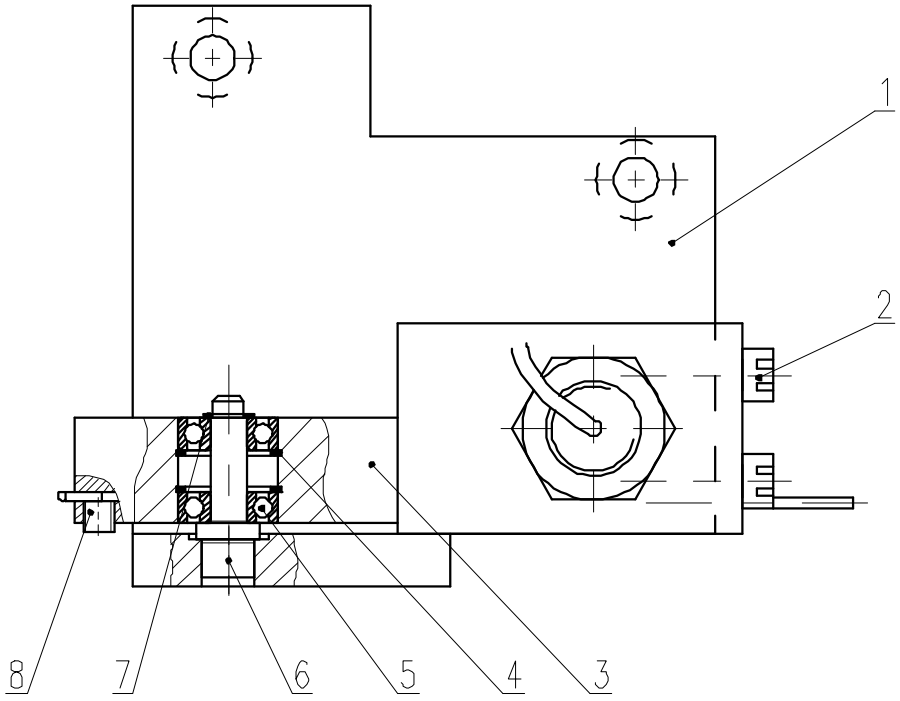
BBS 560/1060 Series 106	SPARE PARTS LIST	Page 1 of 1 17.07.90

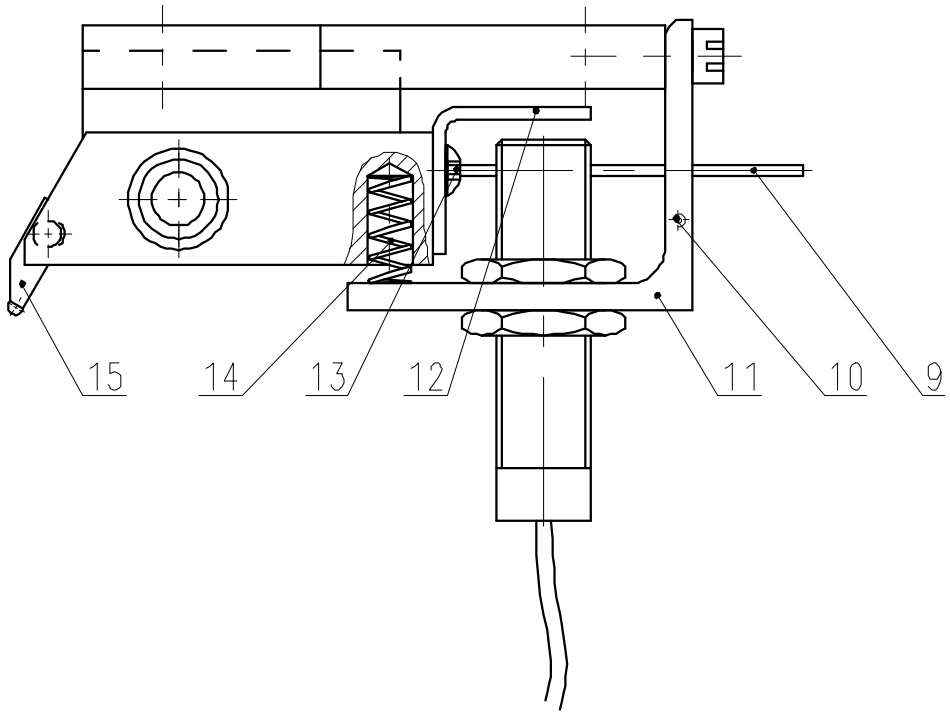
Nr.	Benennung	Stück	Bestellnummer
	OPTION: Band deviation control 01021575	**Drawing 1 of 1**	
1	Allen screw M 6x16-10.9 DIN 912	2	00070807
2	Angle	1	01021567
3	Spring steel wire	1	00860743
4	Analog initiator	-	*
5	Saucer head screw M 5 x 8	2	00275069
6	Angle	1	00758485
7	Pressure spring 8,3x0,8x24x10 IF	1	00791563
8	Support	1	00779512
9	Assy. feeler	1	00779695
10	Protection	1	01021591
11	Bolt	1	00779202
12	Threaded pin M 6x6-10.9 DIN 914	1	00131350
13	Snap ring J 19 DIN 472	2	00791598
14	Ball bearing 607 - 2RS	2	00303267
15	Snap ring 6 x 0,7 DIN 471	1	00073784
16	Assy. holder	1	01021583

* refer to General Drawing - Electrical Parts

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Mat.-Nr.: 01021575 4 000501
Datum: 19 01.1999 Name: ROESCH-M

OPTION: Digital Cutting-Depth Adjustment 00866431 **Drawing 1 of 1**

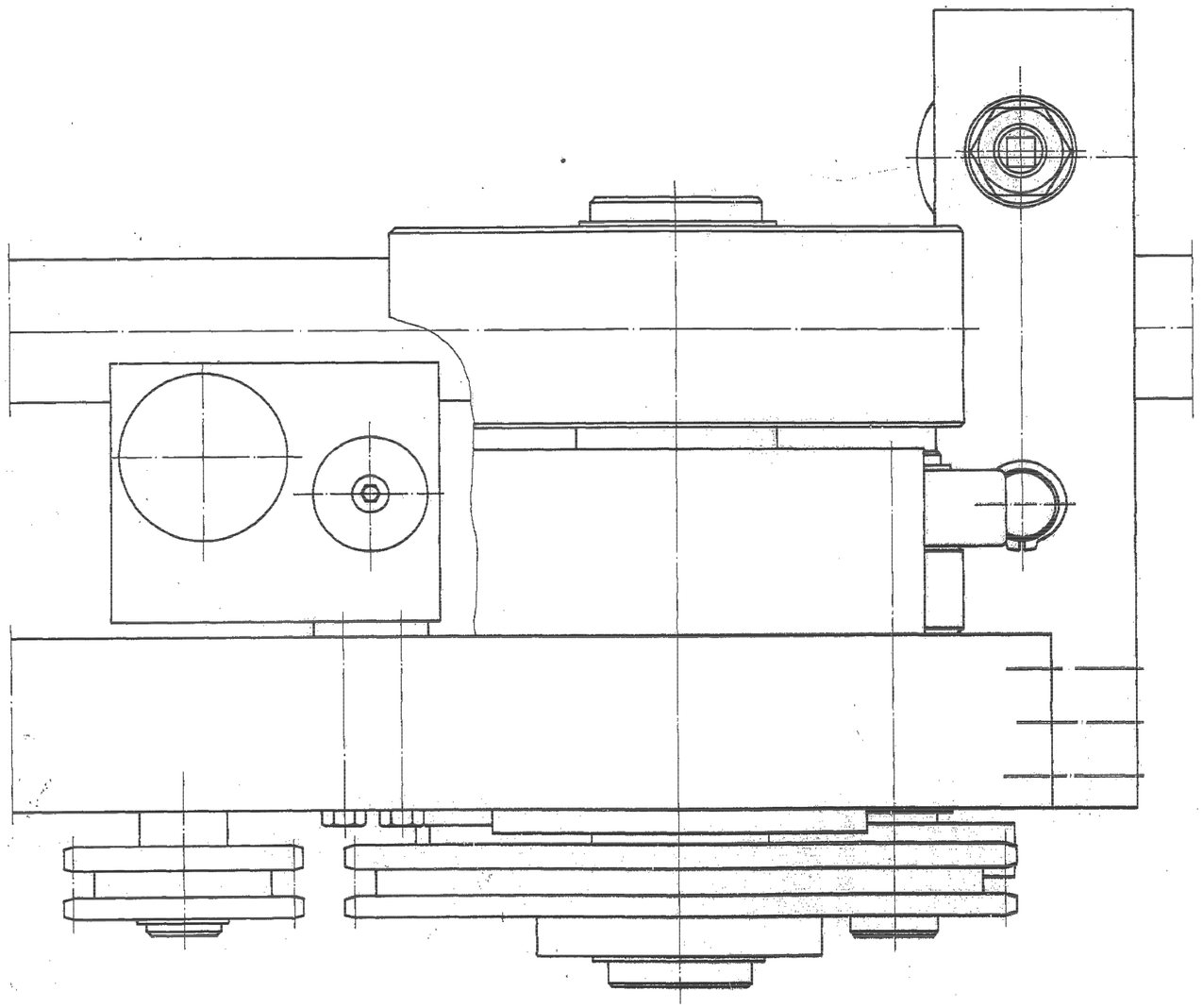
Inch graduation

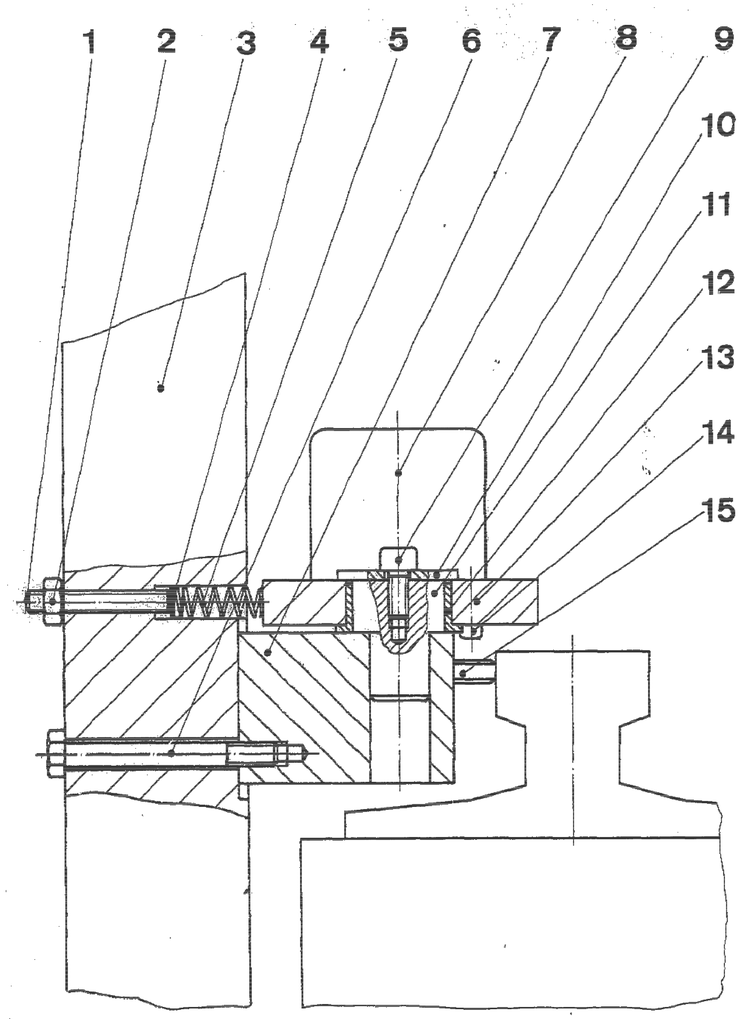
Nr.	Benennung	Stück	Bestellnummer
1	Threaded pin M 8x45-12.9 DIN 913	1	00292028
2	Hex nut M 8 DIN 934 - 5 S	1	00072427
3	Machine base	1	00951072
4	Washer B 5,3 ST DIN 125	1	00072591
5	Pressure spring 9 x 1 x 52 x 13,5	1	00196517
6	Hex screw M 8x70-8.8 DIN 933	2	00362654
7	Holder	1	00761141
8	Encoder	1	*
9	Allen screw M 8x16-10.9 DIN 912	1	00070963
10	Washer	1	00326682
11	Bolt	1	00760250
12	DU-bushing 30/34 x 16	1	00321028
13	Support(Inch graduation)	1	00761176
14	Allen screw M 4x12-10.9 DIN 912	3	00084441
15	Track roller (Inch graduation)	1	00757527

* refer to General Drawing - Electrical Parts

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BBS 1260/1560
Serie 102

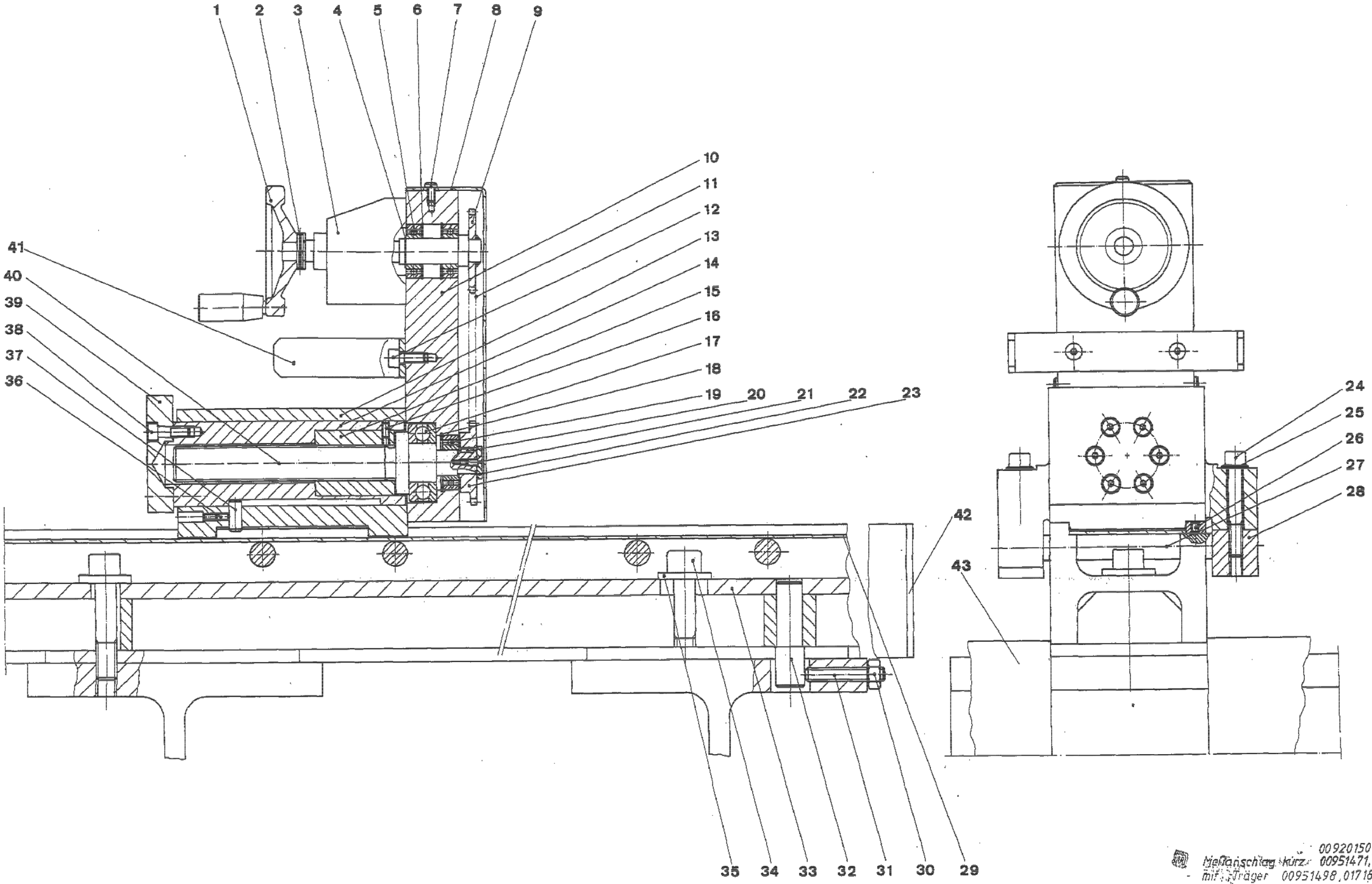
Digitale Schnitttiefenmessung (Zollteilung fuer Sägeteil) 1 0866431,01345265,01344110 00920665
Cutting depth adjustment (Inch graduation for saw unit)
Reglage digital de profondeur de coupe (Graduation en pouces pour)

Zeichnung 1 von 1
Drawing 1 of 1
Dessin 1 de 1

07.12.87

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Measuring stop, short design 00951471	**Drawing 1 of 1**	
	with support , mm-Graduation 00951498		
	Measuring stop, short design 01021982		
	with support, Inch-Graduation 01021974		
1	Handwheel	1	00276227
2	Clamping pin 5 x 30	1	00073318
3	Dig. position indicator		
	Typ 0502 - 5 I (mm-graduation)	1	00207969
	Dig.Position indicator		
	Typ 0502 - 5.0-I (Inch-Graduation)	1	01022040
4	Snap ring 20 x 1,2 DIN 471	1	00073857
5	Ball bearing 6004-RS	2	00023531
6	Snap ring 42 x 1,75 DIN 472	2	00241245
7	Saucer head screw M6x8	3	00121029
8	Protective Cover	1	00835501
9	Assy. sprocket	1	00843504
10	Roller chain 3/8"x7/32" 53G1d		
	DIN 8187	1	00267945
	Chain joint 3/8" x 7/32"1E DIN8187	1	00241547
11	Support	1	00835048
12	Allen screw M8x20-10.9 DIN 912	2	00070971
13	Support	1	00833908
14	Bushing	1	00834580
15	Spindle nut	1	00835021
16	Threaded pin M6x12-12.9 DIN 913	1	00349992
17	Axial bearing 51 306	1	00295094
18	Snap ring 42 x 1,75 DIN 472	1	00241245
19	Ball bearing 6004-RS	1	00023531
20	Key A 6x6x10 DIN 6885	1	00087084
21	Countersunk screw M6x16-8.8 DIN 7991	1	00380725
22	Washer	1	00843687
23	Sprocket	1	00843679
24	Allen screw M10x70-10.9 DIN 912	2	00071269
25	Washer B10,5 -ST DIN 125	2	00072621
26	Threaded pin M6x10-10.9 DIN 914	4	00086711
27	Bolt	4	00843725
28	Clamping piece	2	00843733

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Measuring stop, short design 00951471	**Drawing 1 of 1**	
	with support , mm-Graduation 00951498		
	Measuring stop, short design 01021982		
	with support, Inch-Graduation 01021974		
29	Cover	1	00907197
30	Hex nut M12 DIN 934-8 S	1	00591238
31	Threaded pin M12x60 DIN 913	1	00322393
32	Bolt	1	00907189
33	Assy. carrier (mm-Graduation)	1	00951048
	Assy. carrier (Inch-Graduation)	1	01001167
34	Washer 17 -ST DIN 7349	2	00391328
35	Allen screw M16x80-10.9 DIN 912	2	00086673
36	Threaded pin M6x12-12.9 DIN 913	1	00349992
37	Parallel pin 10m6x24 DIN 7979	1	00922315
38	Allen screw M10x45-10.9 DIN 912	4	00071218
39	Plate	1	00907170
40	Spindle	1	00835013
41	Grip	1	00907081
42	Rail	1	01314572
43	Protective plate	2	01315110



00920150,01887785
Meßanschlag kurz 00951471,01718444
mit Träger 00951498,01718452
Zollteilung 01021982,01912208
mit Träger 01021974

Measuring stop

Butée de mesure

Zeichnung 1 von 1

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Measuring stop 00919993	**Drawing 1 of 1**	
	with Inch-Graduation 00603589		
1	Sprocket	1	00565067
	Roller chain 6mm 109 Gld	1	00627240
	Chain joint 1E Nr. 100603	1	00627259
2	Digital position indicator		
	Type: 0502-10,0 I (mm-graduation)	1	00264709
	Digital position indicator		
	Type: 0502-10 I (Inch-graduation)	1	00314803
3	Spring pin 4 x 40 DIN 1481	1	00073296
4	Ball bearing 6003-RS	2	00326666
5	Snap ring 17 x 1,0 DIN 471	1	00097454
6	Snap ring 35 x 1,5 DIN 472	1	00073989
7	Bolt	1	00565083
8	Safety handwheel		
	GN 321-200-K18-A-DR	1	00692034
	Key A6x6x30 DIN 6885	1	00074284
9	Washer	1	00340251
10	Allen screw M6x12-10.9 DIN 912	1	00070785
11	Snap ring 35 x 1,5 DIN 472	4	00073989
12	Ball bearing 6003-RS	2	00326666
13	Shaft	1	00565148
14	Gear	1	00565091
	Key 6x6x30 DIN 6885	1	00074284
15	Ball bearing 6003-RS	1	00326666
16	Key A12x8x80 DIN 6885	2	00243973
17	Assy. support	1	00845000
18	Allen screw M 16x90-10.9 DIN 912	4	00392332
19	Washer 17-St DIN 7349	4	00391328
20	Snap ring 17x 1,0 DIN 471	3	00097454
21	Allen screw M10x25-10.9 DIN 912	8	00071153
22	Sprocket	1	00565040
23	Taper pin 12 x 36 - ST DIN 7978	4	00296953
24	Spring pin 2,5 x 10 DIN 1481	1	00143774
25	Assy. stop rail	1	00565202
26	Allen screw M 10x25-10.9 DIN 912	4	00071153
27	Slide	2	00569100

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Measuring stop 00919993	**Drawing 1 of 1**	
	with Inch-Graduation 00603589		
28	Snap ring 35x1,5 DIN 472	4	00073989
29	Key A6 x 6 x 25 DIN 6885	2	00074276
30	Gear z = 30	2	00565113
31	Bevel gear	2	00565293
32	Key 5x5x25 DIN 6885	2	00074241
33	Washer	2	00761974
34	Allen screw M10x30-10.9 DIN 912	8	00071161
35	Cover	2	00569208
36	Plate spring	28	00026670
37	Spindle bearing	2	00762008
38	Key A10x8x40 DIN 6885	2	00295930
39	Allen screw M 8 x 20-10.9 DIN 6912	8	00282324
40	Ring	2	00761966
41	Shaft nut M45 x 1,5	2	00867489
	Snap ring MB 9	2	00867497
42	Ball bearing 6213-RS	2	00352209
43	Key A14x9x30 DIN 6885	2	00563420
44	Bevel gear No. 381154	2	00563277
45	Spindle nut with	1	00761982
	right-hand thread		
	Spindle nut with	1	00761990
	left-hand thread		
46	Spindle	1	00563234
47	Assy.Spindle protection	1	00776890
48	Allen screw M6x20-10.9 DIN 912	2	00070823
49	Washer	2	00340251
50	Assy. support	1	00762016
51	Ball bearing	2	00326666
52	Bearing block	2	00670766
53	Allen screw M8x60-10.9 DIN 912	4	00071072
54	Shaft	2	00565237
55	Ball bearing 6004-2Z	2	00243299
56	Parallel pin 6m6 x 30 DIN 6325	2	00238775
57	Shaft	1	00670758
58	Allen screw M 10x130-10.9 DIN 912	2	00220280

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Measuring stop 00919993	**Drawing 1 of 1**	
	with Inch-Graduation 00603589		
59	Cam rail	2	00692158
60	Cam BNN 520-UB-25	2	00375993
61	Spindle	1	00564133
62	Cable drag chain No.102.48 34 links	1	00776769
	Connection piece 100.1 with bore	1	00613843
	Connection piece 100.2 with bore	1	00613851
63	Assy. spindle protection	1	00776904
64	Saucer head screw M 6x8	6	00121029
65	Cover plate	2	00565253
66	Saucer head screw M 6 x 8	4	00121029
67	Base plate	2	00235512
68	Limit switch	2	*
69	Rail	1	00951609
70	Allen screw M12x150-10.9 DIN 912	8	00071501
71	Allen screw M10x30-10.9 DIN 912	2	00071161
72	Locknut M 24 x 1,5 DIN 1804-5.8	4	00096210
73	Assy. rail	1	00845027
74	Snap ring A12 DIN 471	2	00073822
75	Roller track 305801	2	00024384
76	Bolt	2	00348368
77	Snap ring 17 x 1,0 DIN 471	1	00097454
78	Hub FS Nr. 612020	1	00776742
	D - 18 H7 with key slot 6 mm		
	Key A 6 x 6 x 30 DIN 6885		00074284
79	Washer	1	00340251
80	Allen screw M 6 x 20-10.9 DIN 912	1	00070823
81	Sprocket	1	00800465
82	Snap ring 35 x 1,5 DIN 472	2	00073989
83	Assy. support	1	00762024
84	Assy. protection	1	00670820
85	Roller chain 3/8" x 7/32"	1	00267961
	Chain joint 1E 3/8" x 7/32"		00241547

* refer to General Drawing-Electrical Parts

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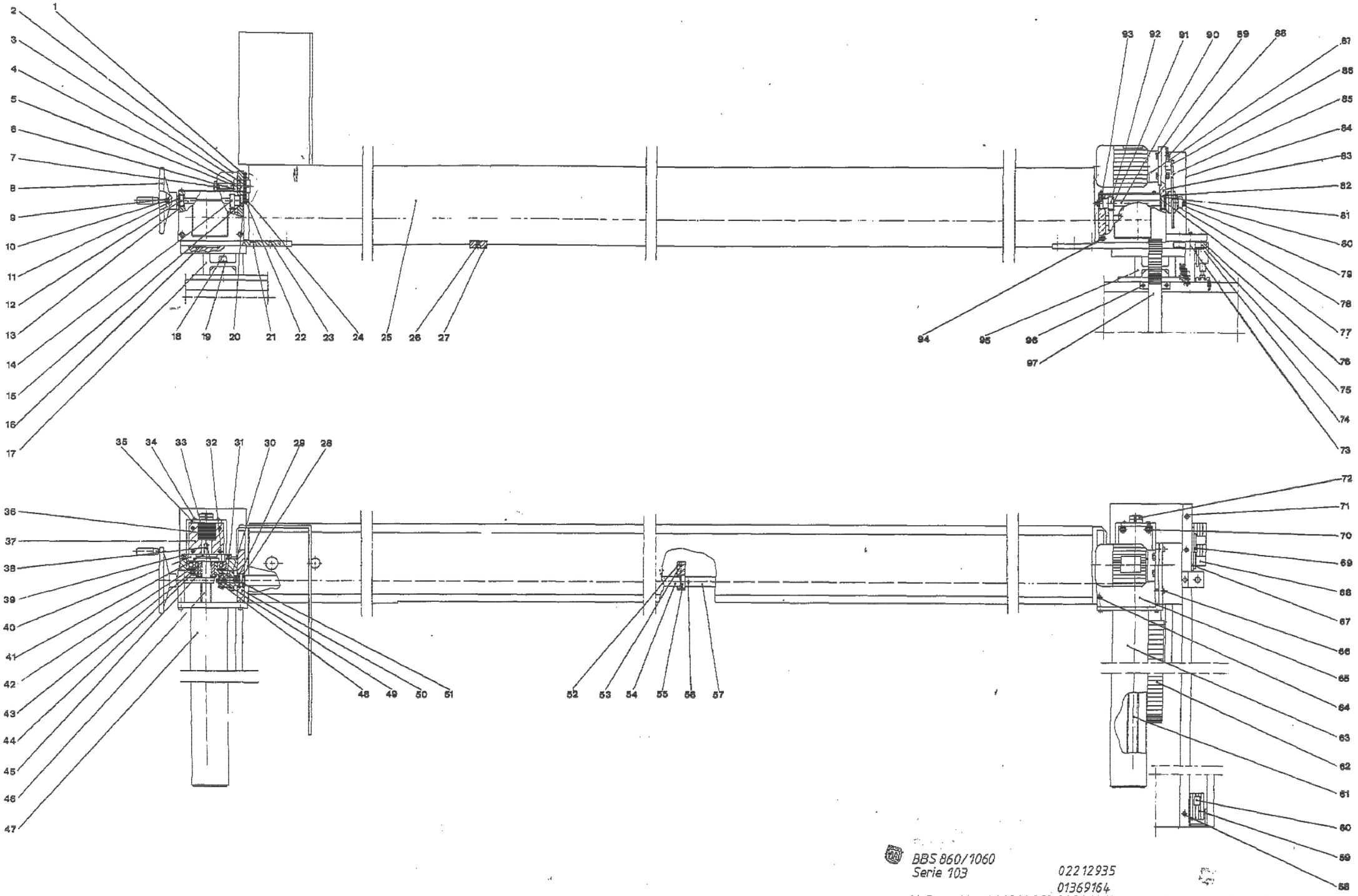
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Nr.	Benennung	Stück	Bestellnummer
	OPTION: Measuring stop 00919993	**Drawing 1 of 1**	
	with Inch-Graduation 00603589		
86	Sprocket	1	00800430
87	Motor	1	*
88	Hex nut M6 DIN 934 - 5S	4	00072389
89	Hex screw M 6x40-8.8 DIN 931	4	00070009
90	Shaft	1	00565148
91	Snap ring 17 x 1,0 DIN 471	3	00097454
92	Gear z= 20	1	00565091
	Key 6 x 6 x 30 DIN 6885		00074284
93	Ball bearing 6003-RS	2	00326666
94	Allen screw M12 x 40-10.9 DIN 912	8	00392332
95	Assy. support	1	00845019
96	Allen screw M6x16-10.9 DIN 912	2	00070807
97	Assy. holder	1	00951625

* refer to General Drawing-Electrical Parts

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BBS 860/1060
Serie 103

02212935
01369164

Meßanschlag 00919993,00866474,
Measuring stop
Butéé de mesure
mit Zollteilung 00603589

Zeichnung 1 von1
Drawing 1 of 1
Dessin 1 a 1

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Ersatzteile
Spare parts
Pieces de rechange

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Electro-mechanical measuring stop 01007254 Drawing 1 of 1		
1	Hex screw M 8x20-8.8 DIN 933	4	00070270
2	Protective plate (L= 880 mm)	1	01560891
3	Saucer head screw M 6 x 8	36	00121029
4	Allen screw M 12x80-10.9 DIN 912	2	00071447
5	Assy. holder	1	00902233
6	Cardan shaft No. 0105113		
	Nab ϕ 36 Bore ϕ 20H7 + 18H7		
	S=820mm little play	1	00920606
7	Rail	1	01314572
8	Assy. guide	1	00950874
9	Allen screw M 10x30-10.9 DIN 912	4	00071161
10	Roller chain 3/8"x7/32" 53 links		
	DIN 8187	2	00267945
	Chain joint 1E 3/8"x7/32" DIN 8187	1	00241547
11	Allen screw M 10x25-10.9 DIN 912	12	00071153
12	Support	1	00902128
13	Protective plate	1	00902209
14	Assy. stop	1	01000373
15	Allen screw M 12x35-10.9 DIN 912	1	00071374
16	Assy. guide	1	00950882
17	Swivel joint L = 885 mm	1	00920614
18	Assy. guide	1	00950866
19	Protective plate	2	00950343
20	Housing	1	00902039
21	Protective plate	12	00950807
22	Countersunk screw M 6x8-8.8 DIN 7991	8	00604860
23	Roller chain 1"x6mm 79 links		
	DIN 8187	1	00920770
	Chain joint 11/E Nr.100 603 DIN 8187	1	00627259
24	Protective plate	1	00902195
25	Support	2	00902101
26	Stop	2	01006584
27	Allen screw M 16x25-10.9 DIN 912	2	00605905
28	Rail	2	01006576
29	Housing	1	00902020

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Electro-mechanical measuring stop 01007254 Drawing 1 of 1		
30	Plate spring 60x30,5x2,75 DIN 2093	20	00199141
31	Key A 18x11x70 DIN 6885	2	00445762
32	Spindle nut	2	00902047
33	Allen screw M 5x12-10.9 DIN 912	8	00070645
34	Spindle	1	00950815
35	Allen screw M 6x16-10.9 DIN 912	8	00070807
36	Bushing	2	00902098
37	Bearing cover	2	00902071
38	Axial-angu.ball bearing ZKLN 3062-2RS	2	00376752
39	Washer	2	00902136
40	Key 6x6x30 DIN 6885	1	00074284
41	Sprocket	2	00902152
42	Sprocket	1	00902160
43	Washer	2	00902144
44	Allen screw M 8x20-10.9 DIN 912	2	00282324
45	Eccentric bushing	1	00902187
46	Allen screw M 5x25-10.9 DIN 912	4	00070688
47	Threaded pin M 4 x 5-12.9 DIN 913	1	00594393
48	Sprocket	1	01006592
49	Hakon-clamping set 100 size 18x40	2	00920517
50	bevel gear transmission		
	KD-80-1:1-200-38,3-C-F	2	00920525
51	Sprocket	2	00902179
52	Allen screw M 6x35-10.9 DIN 912	8	00070866
53	Saucer head screw M 6 x 8	8	00604860
54	Plate	4	00902217
55	Taper pin 10 x 24-St DIN 7978	4	00407003
56	Allen screw M 10x30-10.9 DIN 912	16	00071161
57	Housing cover	2	00902063
58	Housing	3	00902241
59	Allen screw M 12x80-10.9 DIN 912	6	00071447
60	Shaft	3	00902268
61	Ball bearing 6006-2RS	6	00269360
62	Snap ring 30 x 1,5 DIN 471	6	00073903
63	key A 6 x 6 x 20 DIN 6885	6	00241563
64	Protective plate (L= 2445 mm)	1	01560913

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Electro-mechanical measuring stop 01007254 Drawing 1 of 1		
65	Assy. guide	1	01313479
66	Protective plate (L= 2960 mm)	1	01560905
67	Saucer head screw M 6x8	36	00121029
68	Spindle	1	00951366
69	Cardan shaft with length		
	compensation No.0105113		
	Nab ϕ 36 Bore ϕ 18H7+18H7		
	S = 1385 mm little play	3	01006770
70	Distance bolts	4	01560867
71	Allen screw M 8x12-10.9 DIN 912	2	00134120

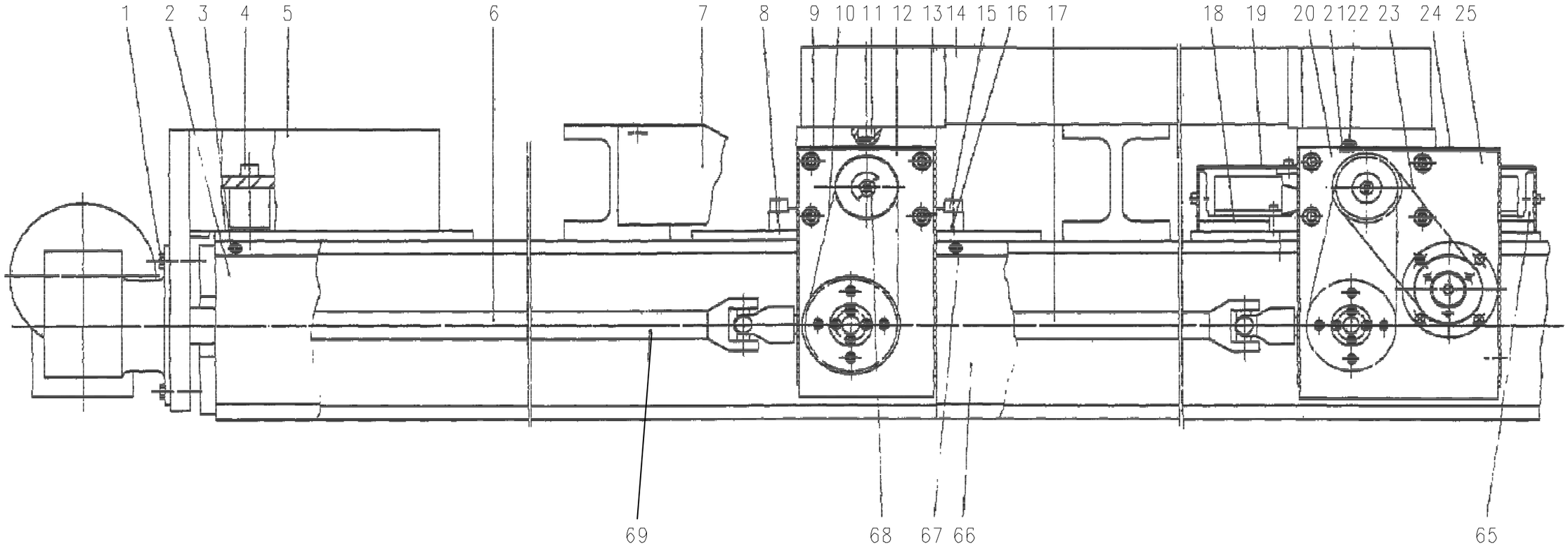
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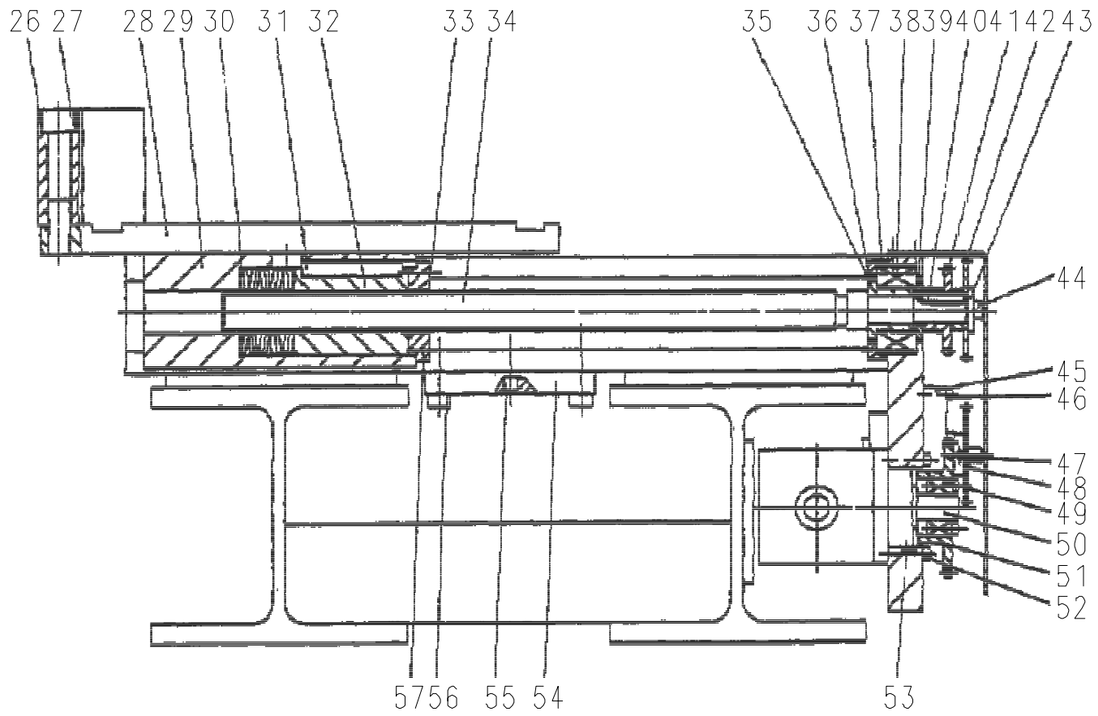
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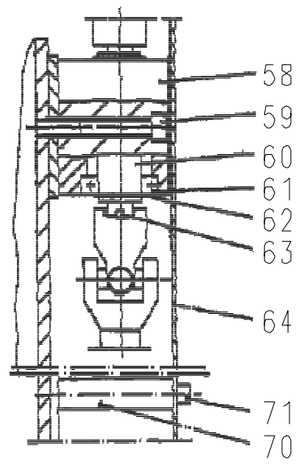
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ERSATZTEILE
SPARE PARTS
PIECES DE RECHANGE







SONDERZUBEHÖR:	ELEKTROMECHANISCHER MESSANSCHLAG	00951420, 01007254, 01470108,
OPTION:	ELECTROMECHANICAL MEASURING STOP	01659421, 01718487, 02516373,
OPTION:	BUTEE DE MESURE ELECTROMECANIQUE	03026396

Mat.-Nr. 03026396 3 000501
Datum: 30.07.2001 Name: TEICHMAN

BBS 560/1060 Series 106	SPARE PARTS LIST	Page 1 of 1 17.07.90

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Clamping device 00866318	**Drawing 1 of 1**	
1	Star grip screw		
	GN 336.4-SK 50-M10-25	1	01543644
2	Assy. lever	1	00868574
3	Pipe	1	00869422
4	Allen screw M 8 x 12-10.9 DIN 912	2	00134120
5	Hex nut M 8 DIN 934 - 5 S	2	00072427
6	Countersunk screw M 6x8-8.8 DIN 7991	2	00604860
7	Ball knob C 40 x M 10 black	2	00028045
8	Threaded bolt	1	00868558
9	Snap ring A 38x1,75 DIN 471	1	00202924
10	Threaded bushing	1	01470639
11	Spindle	1	00868566
12	Spring ping pin 3 x 36 DIN 1481	2	00073229
13	Allen screw M 5x10 -10.9 DIN 912	1	00070637
14	Plate	1	00869449
15	Assy. Column	1	00868582
16	Assy. clamping piece	1	00868590
17	Star grip DIN 6336-GG-63 M 12-E	2	01344161

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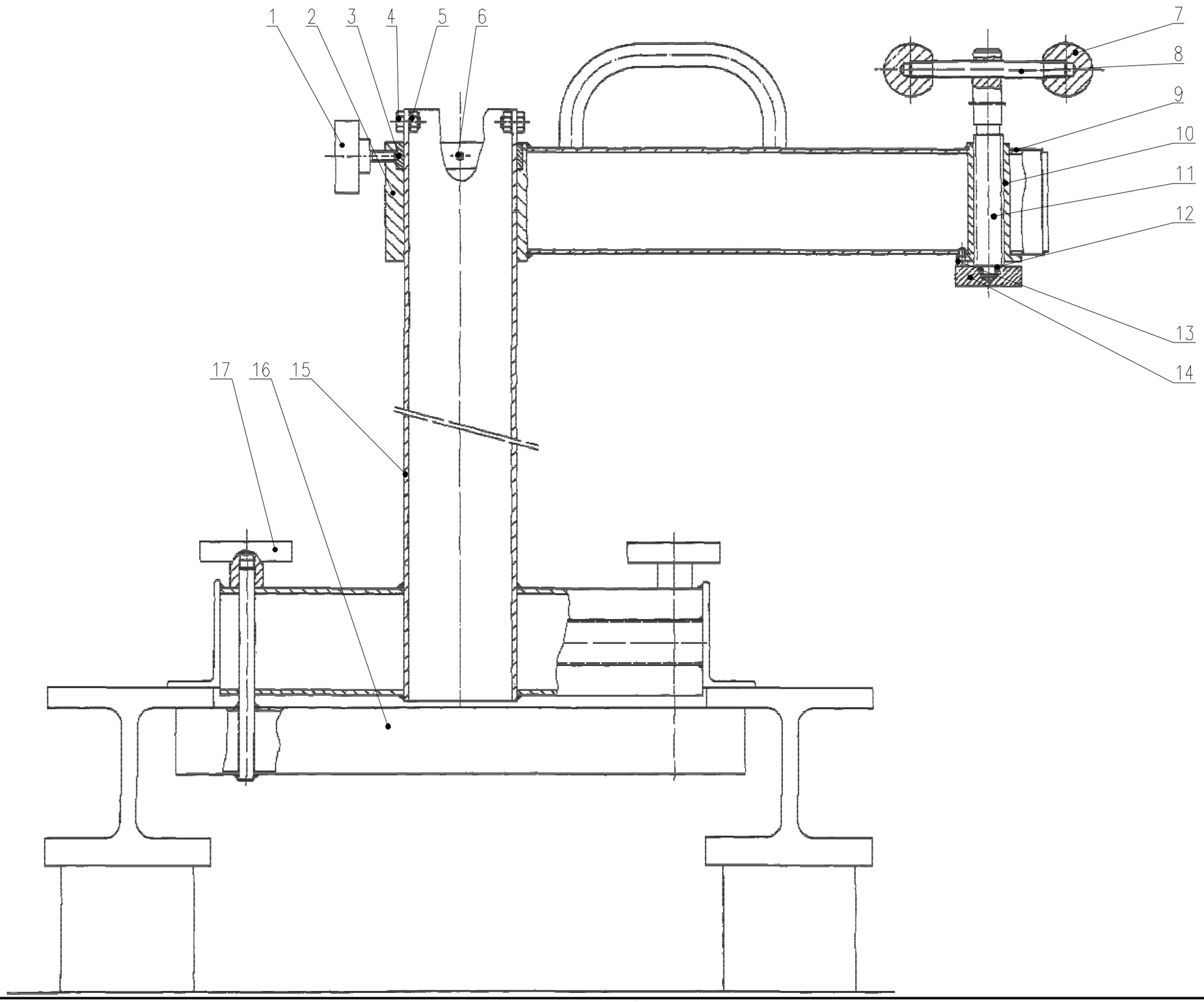
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ERSATZTEILZEICHNUNG
SPARE PARTS
PIECES DE RECHANGE

SONDERZUBEHÖR: SPANNVORRICHTUNG 00866318, 00920193,
OPTION; CLAMPING DEVICE 00920215, 01367692,
OPTION: SAUTERELLE DE FIXATION 03084299



Mat.-Nr.: 00866318 3 000501
Datum: 24.06.1999 Name: TEICHMAN

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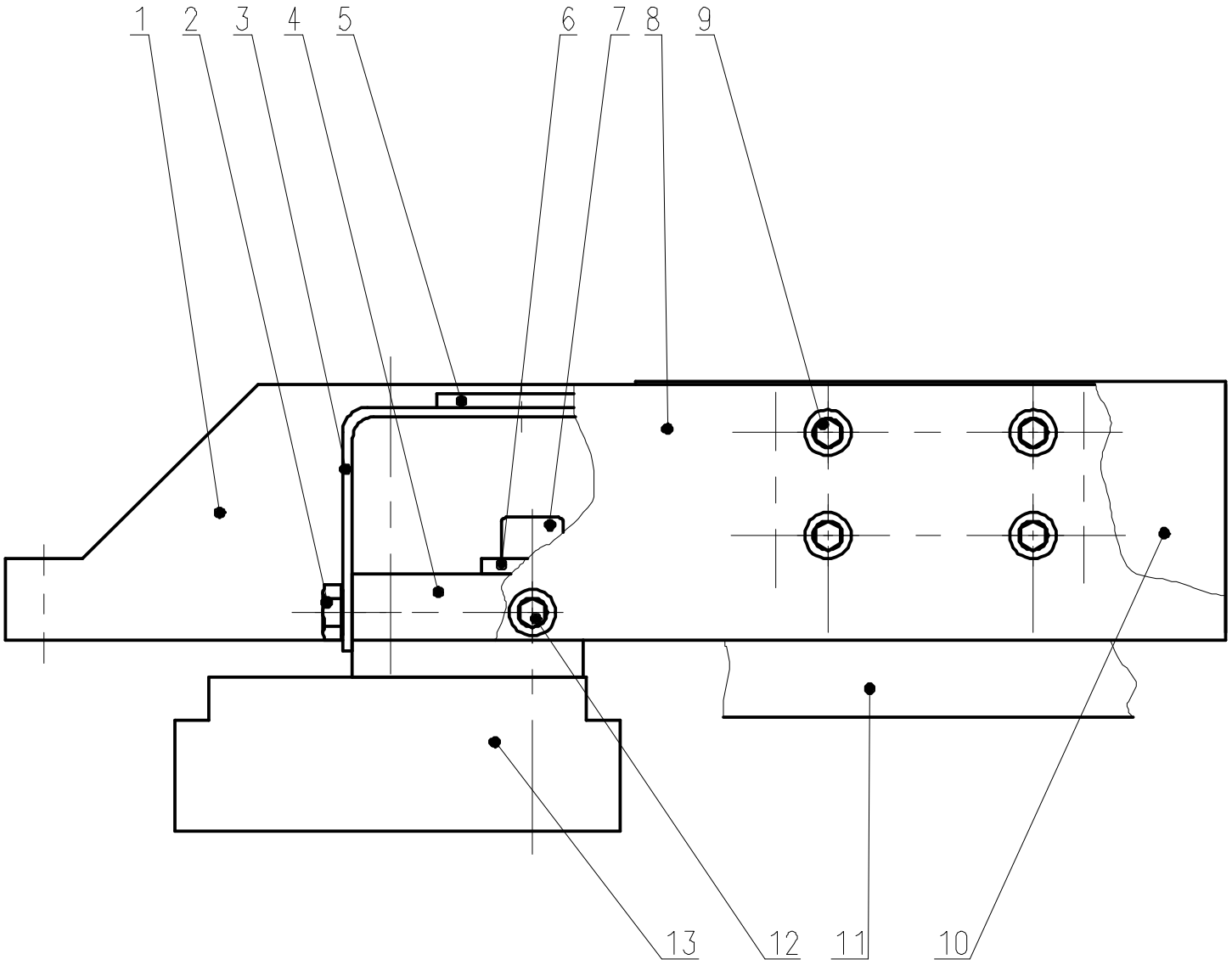
BBS 560/1060 Series 106	SPARE PARTS LIST	Page 1 of 1 17.07.90

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Magnetic clamping plate (rear table) 01417681		**Drawing 1 of 1**
1	Rail	1	01324276
2	Hex screw 12x20-8.8 DIN 933	2	00143944
3	Protective plate	1	01417053
4	Rail	1	01324292
5	Plug No. 10458 R 1 ½"	1	00757276
6	Washer 17-St DIN 7349	1	00391328
7	Allen screw M 16x70-10.9 DIN 912	1	00086665
8	Rail	1	01324268
9	Allen screw M 12x20-10.9 DIN 912	8	00071358
10	Magnetic clamping plate QS230K1 Kabell.		
	8 m (230 x 320 x 98 mm)	1	01022539
11	Steps 550 x 470 x 30	1	00920401
12	Allen screw M 12x20-10.9 DIN 912	4	00071358
13	Rail	1	01324284

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SONDERZUBEHÖR: MAGNETSPANNPLATTE HINTERER TISCH 01417681, 01545604
OPTION: CLAMPING MAGNET REAR TABLE
OPTION: ELEKTRO-AIMANT TABLE AVANT



Mat.-Nr.: 01417681 3 000501
Datum: 12 02.1990 Name: PUSCH

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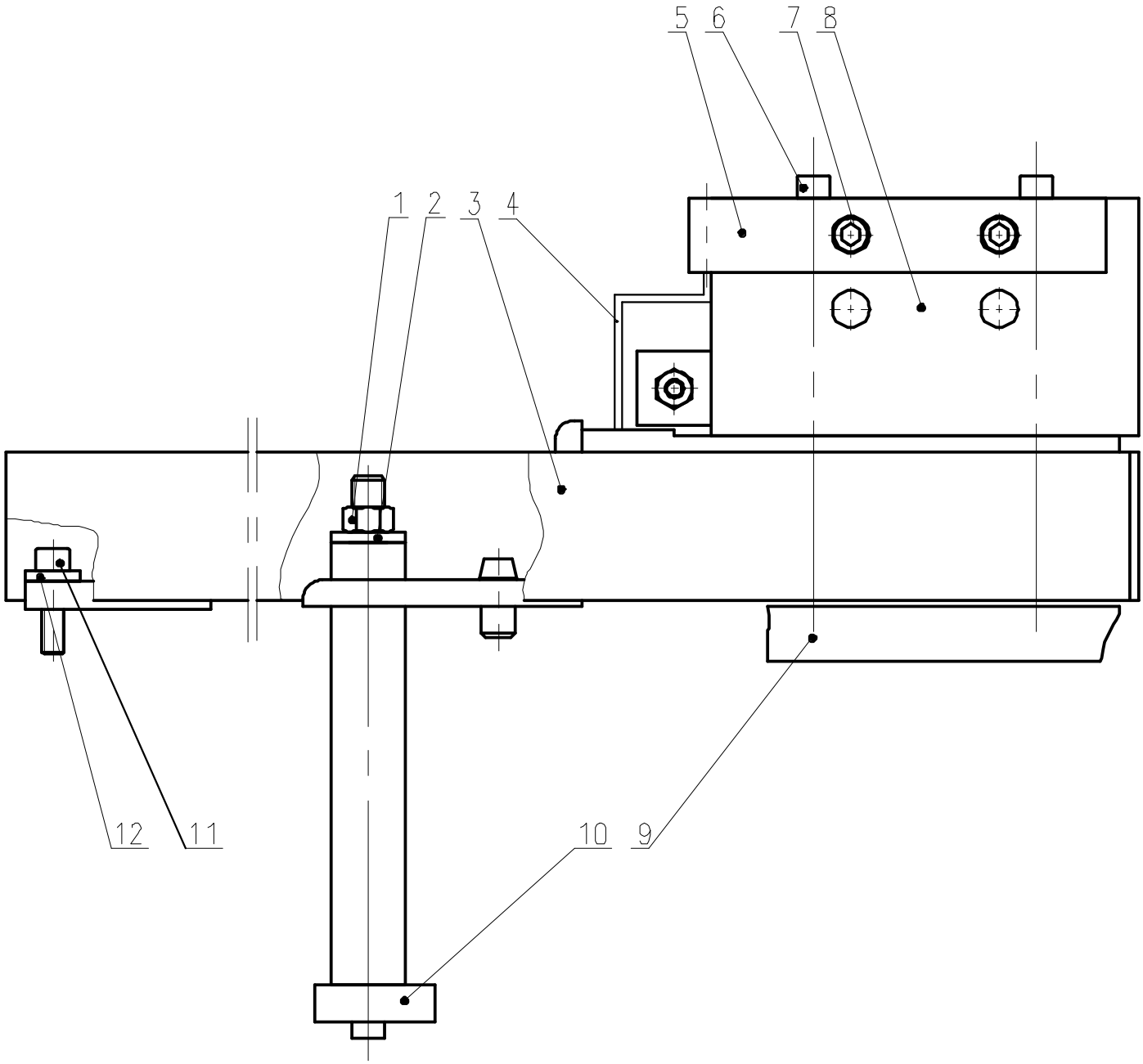
OPTION: Clamping magnet (front Table) 01417673 **Drawing 1 of 1**

Nr.	Benennung	Stück	Bestellnummer
1	Hex nut M 16 DIN 934- 8 S	1	00591246
2	Washer 17-St DIN 7349	1	00391328
3	Assy. frame	1	01324217
4	Cover plante	1	01417061
5	Rail	2	01417045
6	Allen screw M 12x130-10.9 DIN 912	4	00071498
7	Allen screw M 12x20-10.9 DIN 912	4	00071358
8	Magnetic clamping plate QS230 K2		
	cable 8 m (230 x 320 x 128 mm)	1	01022547
9	Steps 1150 x 470 x 30	1	00920290
10	Assy. bolt	1	01324233
11	Allen screw M 18x45-10.9 DIN 912	1	00071390
12	Washer 13-St DIN 7349	1	00183865

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MAGNETSPANNPLATTE VORDERER TISCH 01417673
CLAMPING MAGNETFRONT TABLE
ELECTRO-AIMANT TABLE AVANT



Mat.-Nr.: 01417673 3 000501
Datum: 05 02.1990 Name: PUSCH

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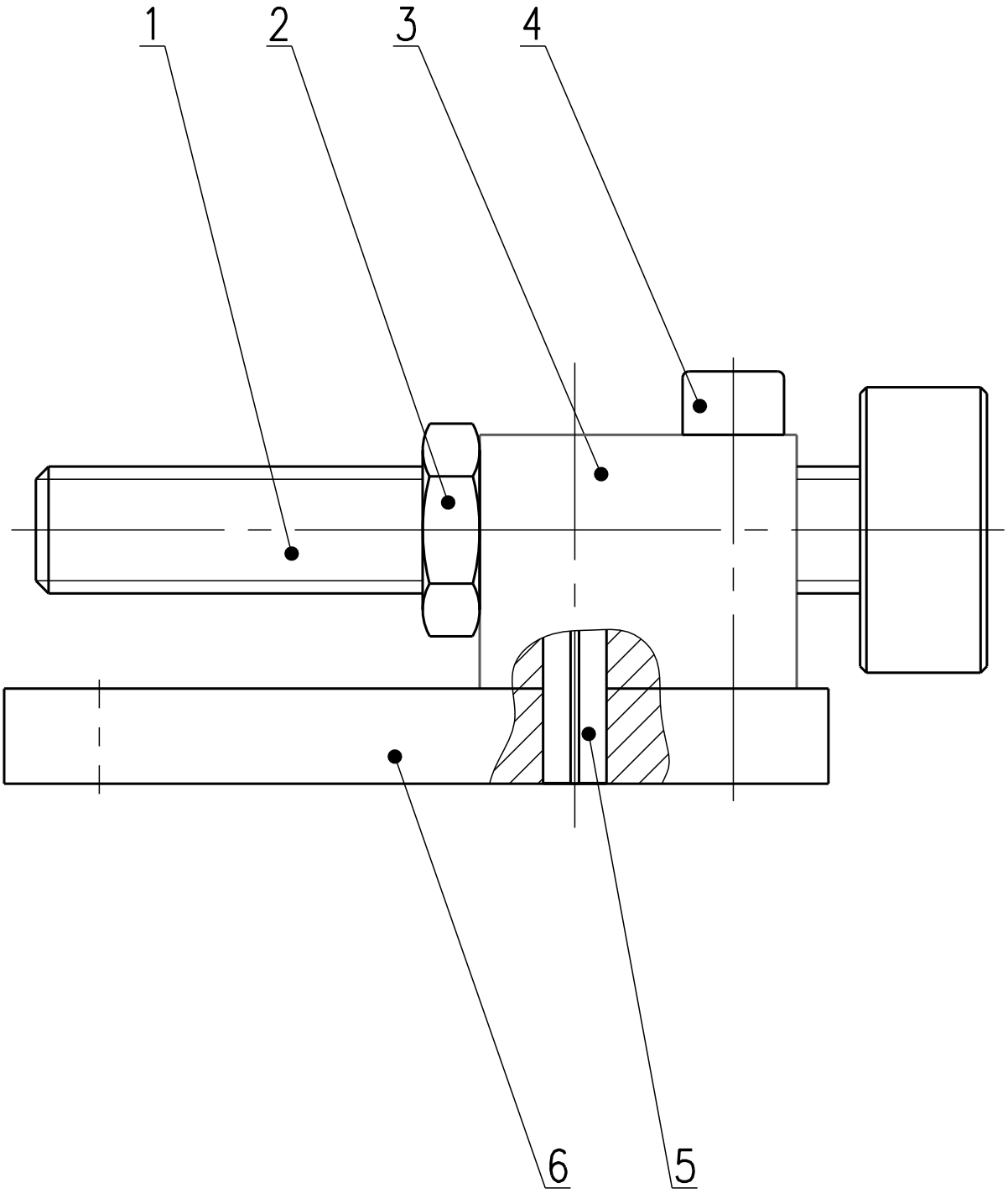
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Nr.	Benennung	Stück	Bestellnummer
	OPTION: Operating panel for clamping magnet 01417703		**Drawing 1 of 1**
1	Assy. spindle	1	01417940
2	Hex nut M 20 DIN 936	1	00072508
3	Support	1	01417932
4	Allen screw M 10x60-10.9 DIN 912	1	00071242
5	Spring pin 10 x 30	1	00073482
6	Rail	3	01368952

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BEDIENTEIL FÜR SPANNMAGNET 01417703
OPERATING PANEL FOR CLAMPING MAGNET
COMMANDE POUR ELECTRO-AIMANT



Mat.-Nr. 01417703 3 000501
Datum: 15.02.1990 Name: PUSCH

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Nr.	Benennung	Stück	Bestellnummer
	OPTION: Bracket for operating panel (Roller rail) 00848085		**Drawing 1 of 1**
1	Assy. holder	1	00950025
2	Hose holder "Adlus"	1	00376892
3	Saucer head screw	5	00121029
4	Hydr.distributor 2H2R 06-10/01 C	1	00803405
5	Holder	1	00950017
6	Allen screw M 8x16-10.9 DIN 912	2	00070963
7	Allen screw M 8x12-10.9 DIN 912	4	00134120
	Hex nut M 8 DIN 934 - 8	2	00072427
8	Protective cover	1	01317288

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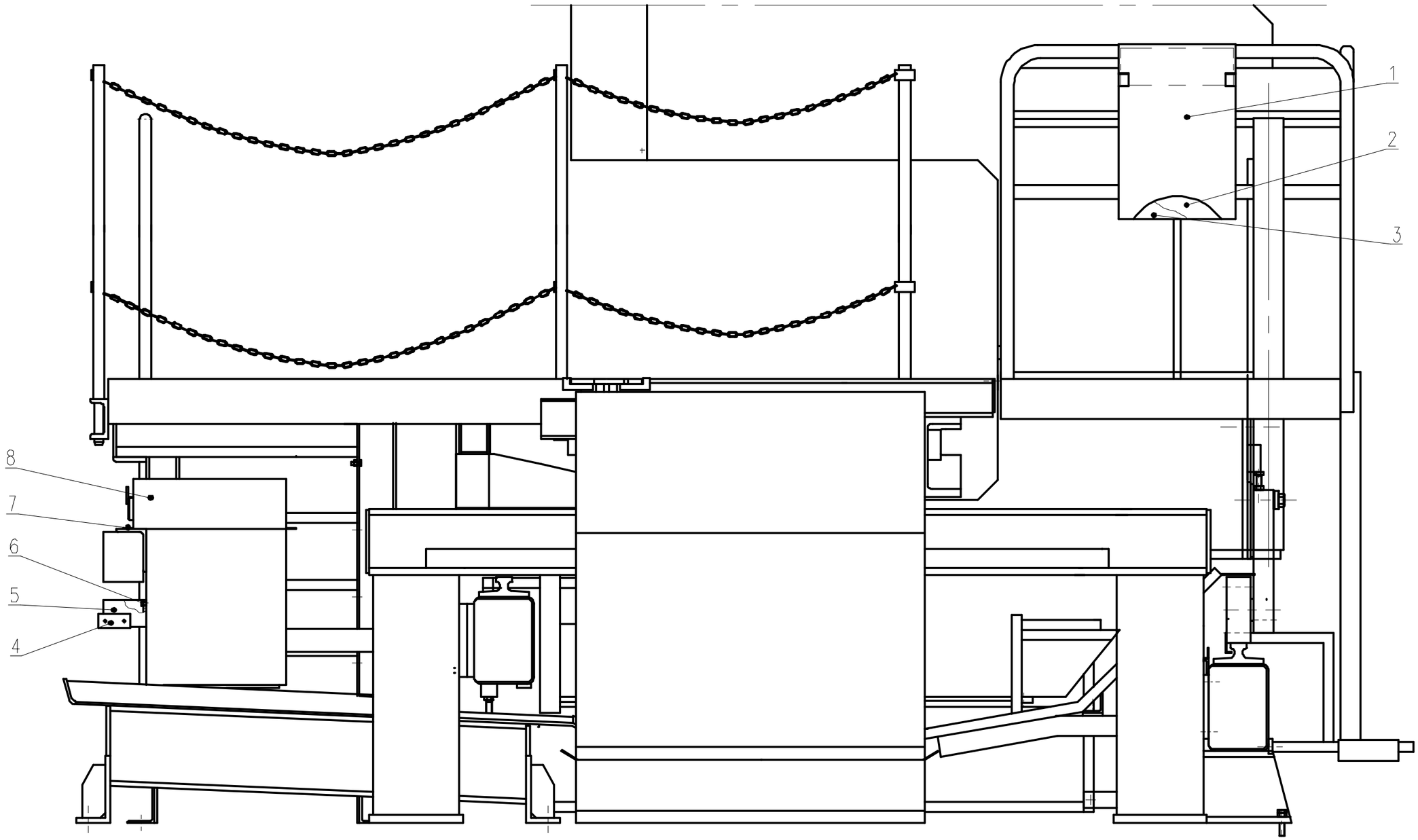
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ERSATZTEILE
SPARE PARTS
PIECES DE RECHANGE

SONDERZUBEHÖR:	BEDIENUNG ROLLENSCHIENE	00848085, 01659464
OPTION:	OPERATING PANEL-ROLLER RAIL	
OPTION:	COMMANDERAILS A ROULEAUX	



Mat.-Nr.: 00848085 3 000501
Datum: 15.05.1990 Name: M. PUSCH

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Roller rail 1,5 m 00950572	**Drawing 1 of 1**	
1	Hose pipe	2	01416286
2	Support plate	1	00907812
3	Allen screw M 16x60-10.9 DIN 912	1	00086657
4	Washer B 17-St DIN 125	1	00072656
5	Assy. frame	1	00950505
6	Bolt	2	00953180
7	DU-stop washer 22x38x1,5	2	00170224
8	Snap ring 10x1,2 DIN 471	4	00073857
9	Assy. lever	1	00907596
10	Bolt	1	00950548
	Snap ring 20x1,2 DIN 471	1	00073857
	DU-Bushing 10/23x20	2	00139378
11	Pulling vice	1	00950556
12	Swivel joint SA 20 C	1	00212784
13	Hex nut	1	00072494
14	Hose pipe 3 TE 8	2,700 m	00590797
	Hose pipe 3 TE 8	2,050 m	00590797
15	Orifice	2	00836710
16	O-Ring 74,0x3,0 N 78 80 shore	1	00416835
17	Cylinder cover	1	00907766
18	Hex nut M 16x1,5 DIN 936-M8	1	00072494
19	Washer B 17-St DIN 125	1	00072656
20	Piston	1	00907715
21	Piston seal SIMKO 80x66x16x32	1	00082171
22	Piston rod	1	00907898
23	O-Ring 74x3,0 N 78 80 shore	1	00416835
24	Cylinder cover	1	00907758
25	Allen screw M 6x12-10.9 DIN 912	4	00070785
26	Cylinder pipe	1	00907731
27	Slotering Q2 Y 032055-25x33x6	1	00241725
28	Scrap ring A 1 25x33x7	1	00241733
29	Cylinder cover	1	00296430
30	Allen screw M 10x260-10.9	4	00935794
31	Hex nut BM 20x1,5 DIN 439-04	1	00072516
32	Swivel joint SI 20 C	1	00241709
33	Snap ring 20x1,2 DIN 471	1	00073857

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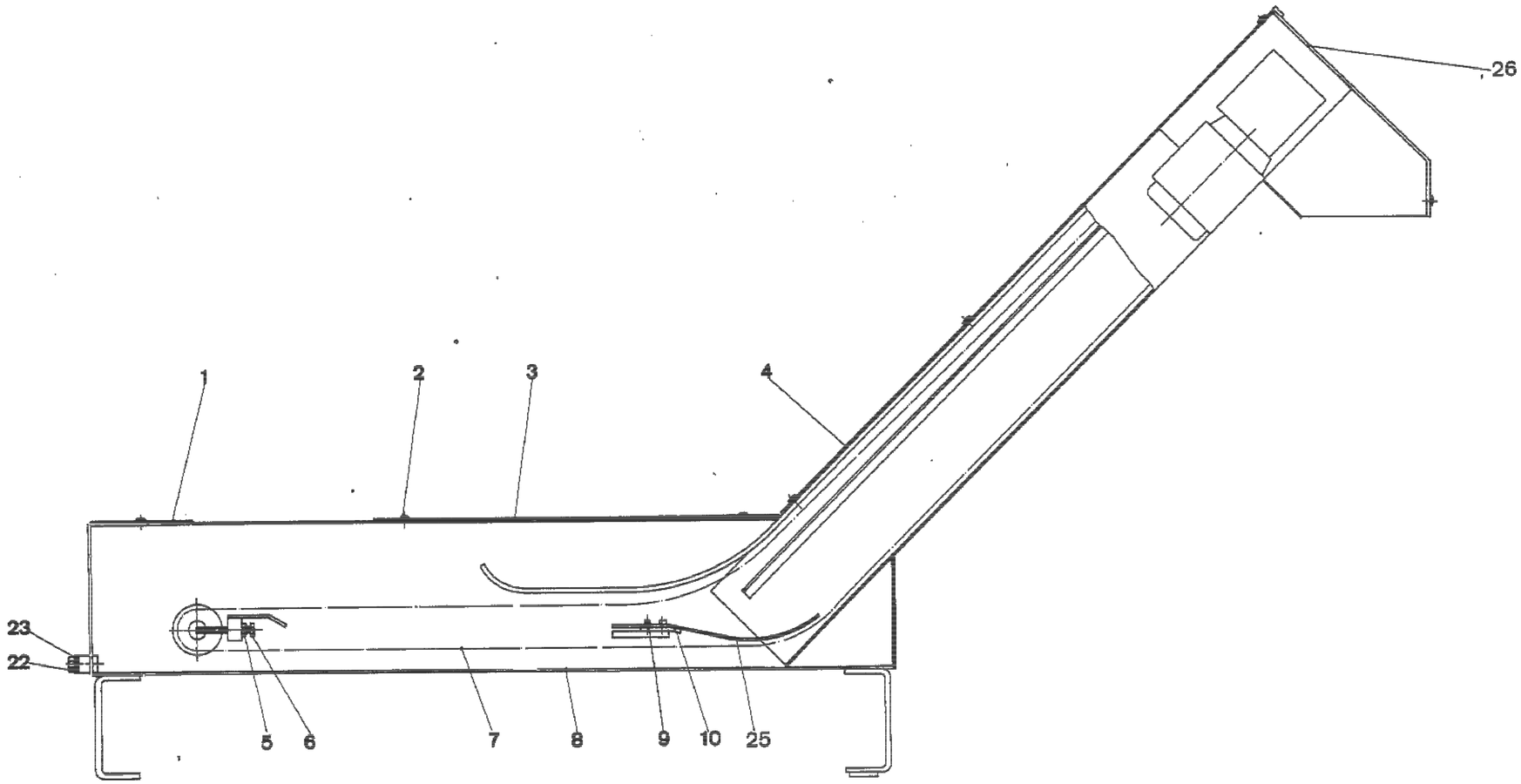
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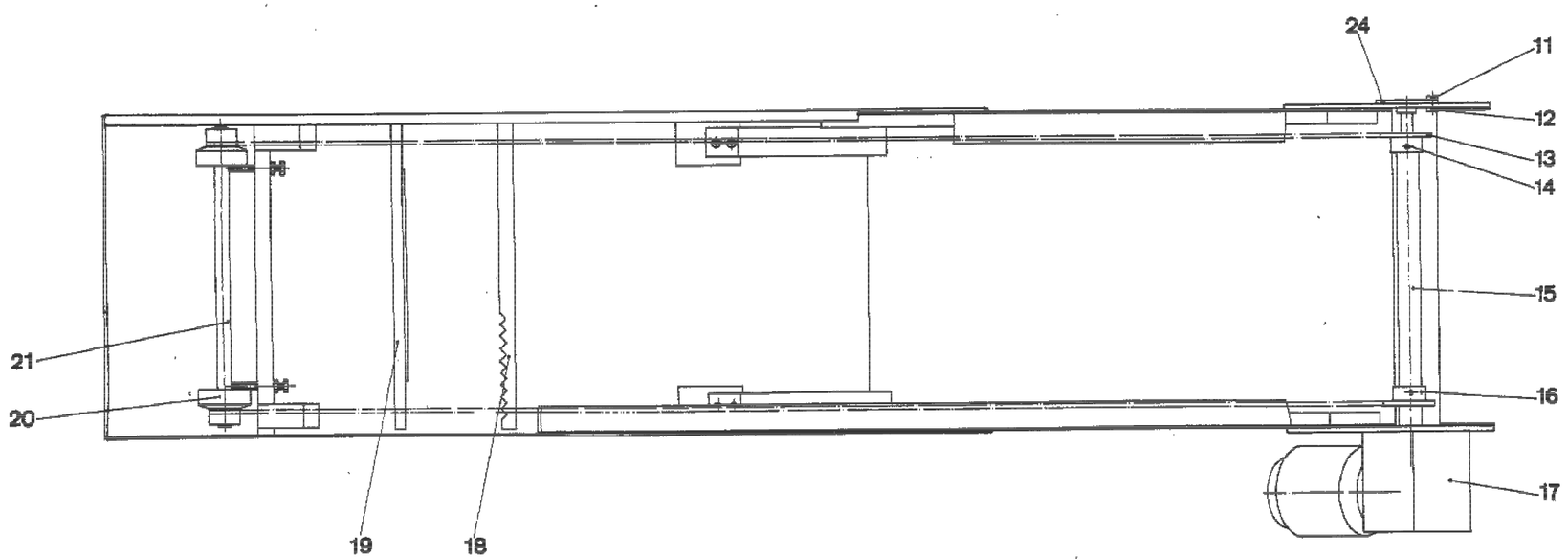
Nr.	Benennung	Stück	Bestellnummer
	OPTION: Roller rail 1,5 m 00950572	**Drawing 1 of 1**	
34	Assy. lever	1	00950564
35	Bearing bolt	2	00953083
36	Needle bushing BK 3020	4	00024724
37	Needle bushing BK 3020	4	00024724
38	Bearing bolt	2	00997826
39	Rail	4	00907634
40	Bearing bolt	2	00907642
41	Bolt	1	00777056
42	Needle bushing BK 3020	4	00024724
43	Hex screw M 12x35 DIN 933-8.8	4	00086800
44	Rail	2	00907650
45	Suspension	2	00907669
46	Hex screw M 12x35-8.8 DIN 933	4	00086800
47	Washer B 13-St DIN 125	4	00072648
48	Bearing bolt	2	00907871
49	Snap ring 20x1,2 DIN 471	2	00078857
50	Roller track 305803	4	00235849
51	Washer B 13-St DIN 125	2	00072648
52	Hex screw M 12x40 DIN 933-8.8	2	00086819
53	Rail	1	00950483
54	Roller chain 1-Fach 5/8"x3/8"		
	23 links DIN 8187	1	00935808
	Chain joint 1E 5/8"x3/8" DIN 8187	1	00240524
55	Assy.sprocket	1	00907804
56	Key A 8x7x30 DIN 6885	1	00235709
57	Snap ring 25x1,2 DIN 471	1	00073873
58	Needle roller Bearing 6206-2RS	2	00249432
59	Shaft	1	00907734
60	Roller chain 1-Fach 5/8"x3/8"		
	27 links DIN 8187	1	00866296
	Chain joint 1 E 5/8"x3/8" DIN	8187	100240524
61	Sprocket	1	00907820
62	Hydraulic motor OMP 200	1	00757357
63	Assy. cover plate	1	00950513
64	Rail	1	00950491
65	Roller	9	00907901

Nr.	Benennung	Stück	Bestellnummer
	OPTION: Roller rail 1,5 m 00950572	**Drawing 1 of 1**	
66	Roller chain 1-Fach 5/8"x3/8"		
	33 links DIN 8187	8	00757349
	Chain joint 1 E 5/8"x3/8" DIN 8187	8	00240524
67	Sprocket	9	00775525
68	Key A 8x7x30 DIN 6885	9	00235709
69	Snap ring 28x1,5 DIN 471	9	00073881
70	Needle roller bearing 6206-2RS	18	00249432
71	Saucer head screw		
	M 6 x 8	5	00121029
72	Hex screw M 8x30 DIN 933-8.8	2	00070297
73	Eccentric bolt	2	00777021
74	Hex screw M 10x25 DIN 933-8.8	2	00070343
75	Roller track 305803	4	00235849
76	Pressure piece	4	00907863
77	Threaded pin M 16x16 DIN 913	4	00131296
78	Hex nut BM 16 DIN 439 - 04	4	00072486

OPTION: Additional Chip conveyor 00603627 — **Drawing 1 of 1**

Nr.	Benennung	Stück	Bestellnummer
1	Cover plate	1	00431516
2	Oval head screw M6x10-4.8 DIN 7985	16	00320919
3	Cover plate	1	00617385
4	Cover plate	1	00617431
5	Hex nut M 8 DIN 934 - 5 S	2	00072427
6	Hex screw M 8x75-8.8 DIN 933	2	00219886
7	Assy. roller chain	1	00617458
8	Assy. chip container	1	00617423
9	Allen screw M 6x10-10.9 DIN 912	4	00070777
10	Plate spring	2	00340073
11	Hex nut M 6 DIN 934 - 5 S	3	00072389
12	Hex screw M 6x16-8.8 DIN 933	3	00070181
13	Sprocket	1	00352381
14	Clamping pin 6 x 36 DIN 1481	2	00073385
15	Shaft	1	00386693
16	Sprocket	1	00352055
17	Gear motor	1	00314404
18	Angle	1	00386642
19	Assy. Angle	24	00386669
20	Roller	2	00342092
21	Axle	1	00386626
22	Cap screw R 3/8"-5S DIN 910	1	00072338
23	Copper ring 16,5x21,5x1,5 DIN 7603 A	1	00026158
24	Flange bearing unit PF 35 - 15 D	1	00200034

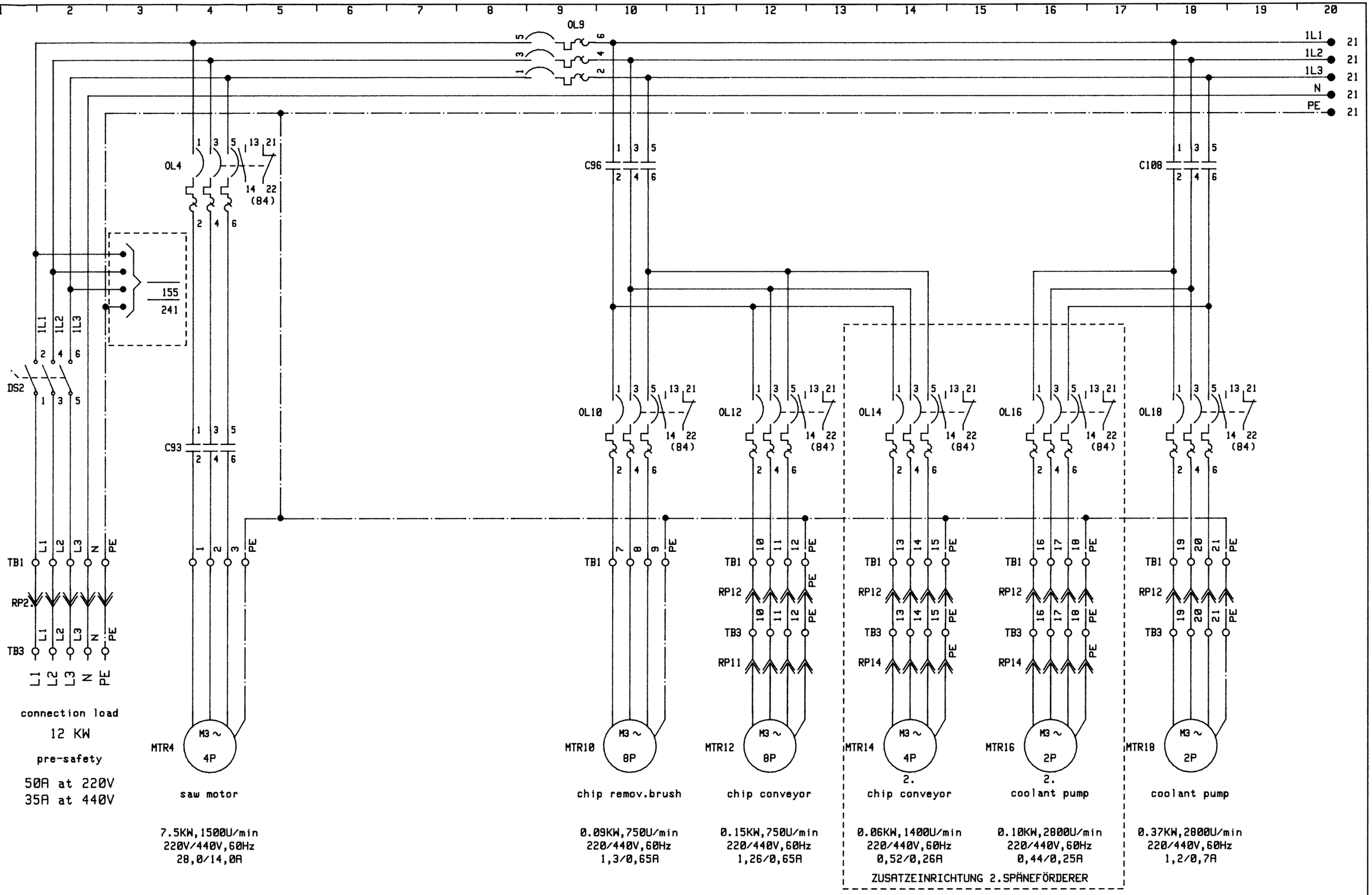




BBS 860/1060
Serie 103

00431877
01857428
Zusätzlicher Späneförderer 00603627
Additional chip conveyor
Evacuateur de copeaux supplementaire

Zeichnung 1 von 1
Drawing 1 of 1
Dessin 1 de 1



KASTO Maschinenbau GmbH & Co KG

Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.

	Datum	Name
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gepr.		
Norm.		

Benennung: BBS 560/1060 220/440V,60Hz "e067"

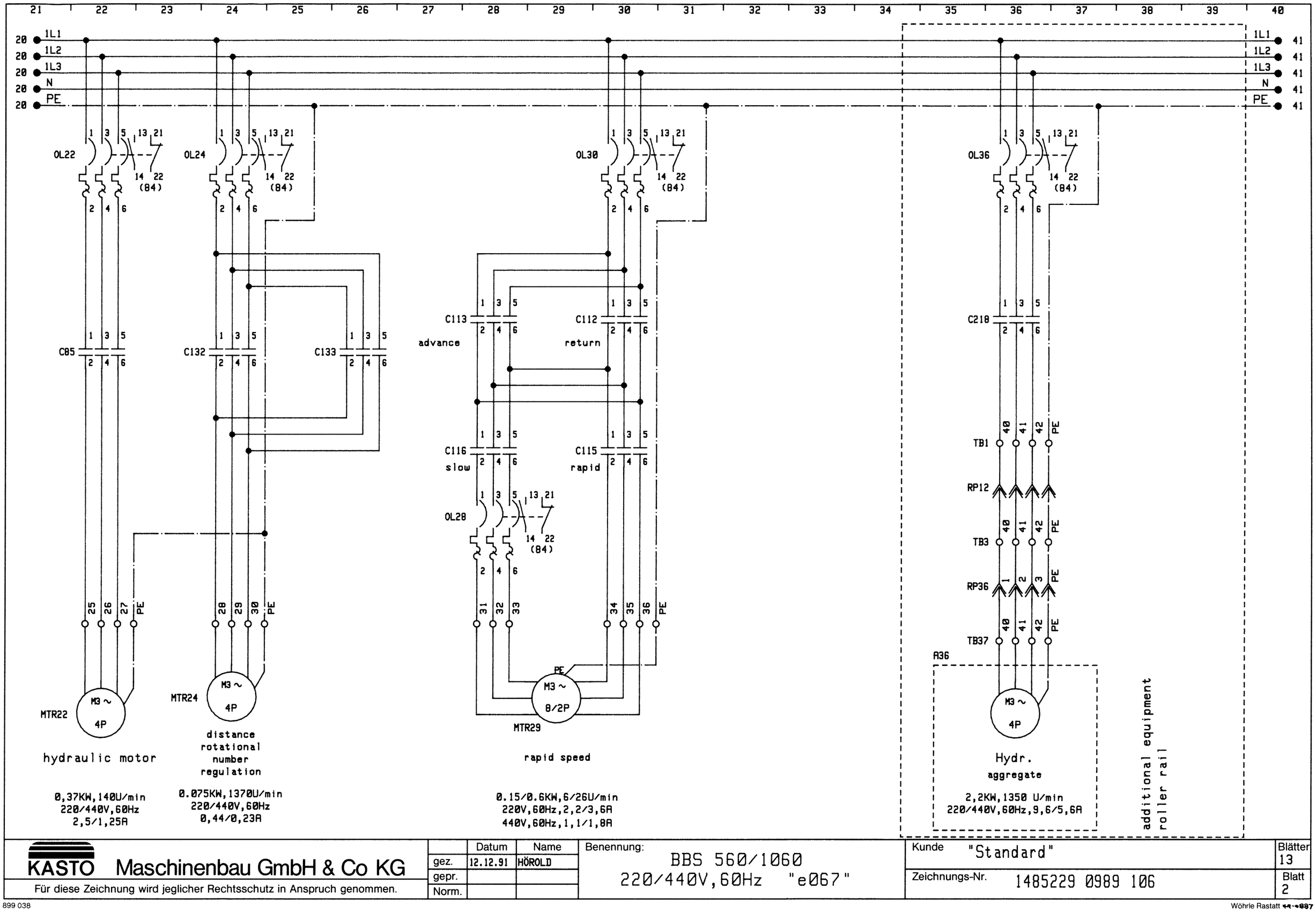
Kunde "Standard"

Zeichnungs-Nr. 1485229 0989 106

Blätter 13

Blatt 1

899 038



KASTO Maschinenbau GmbH & Co KG

Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.

	Datum	Name
gez.	12.12.91	HÖROLD
gepr.		
Norm.		

Benennung: BBS 560/1060 220/440V,60Hz "e067"

Kunde "Standard"

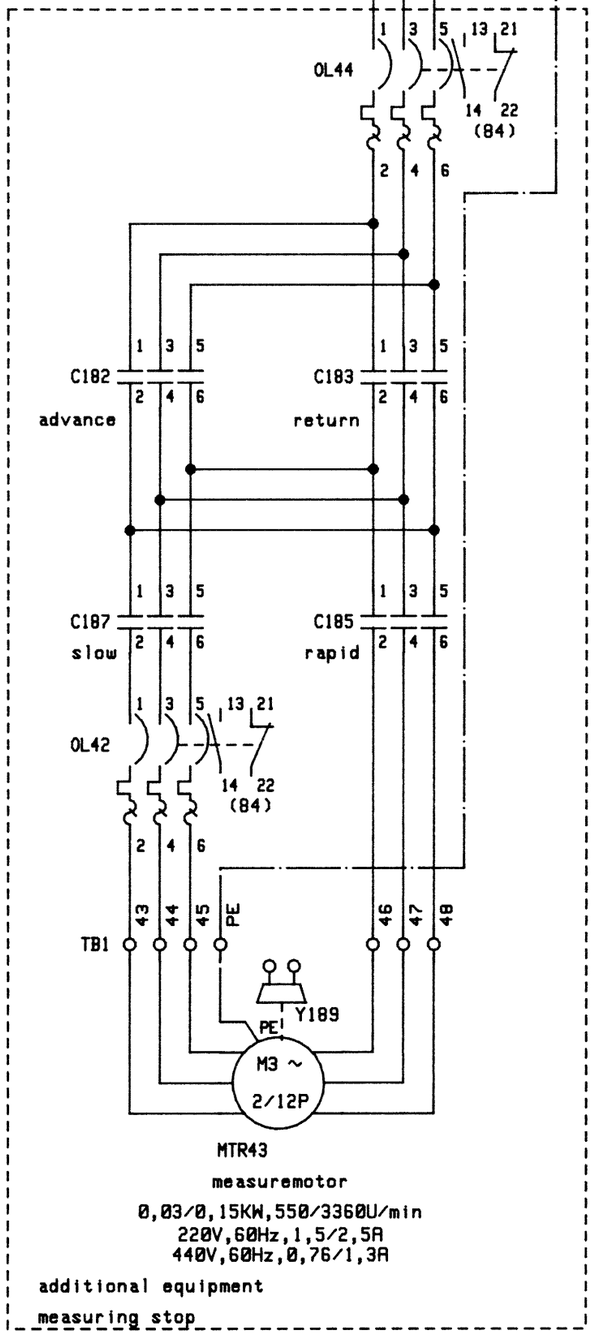
Zeichnungs-Nr. 1485229 0989 106

Blätter 13

Blatt 2

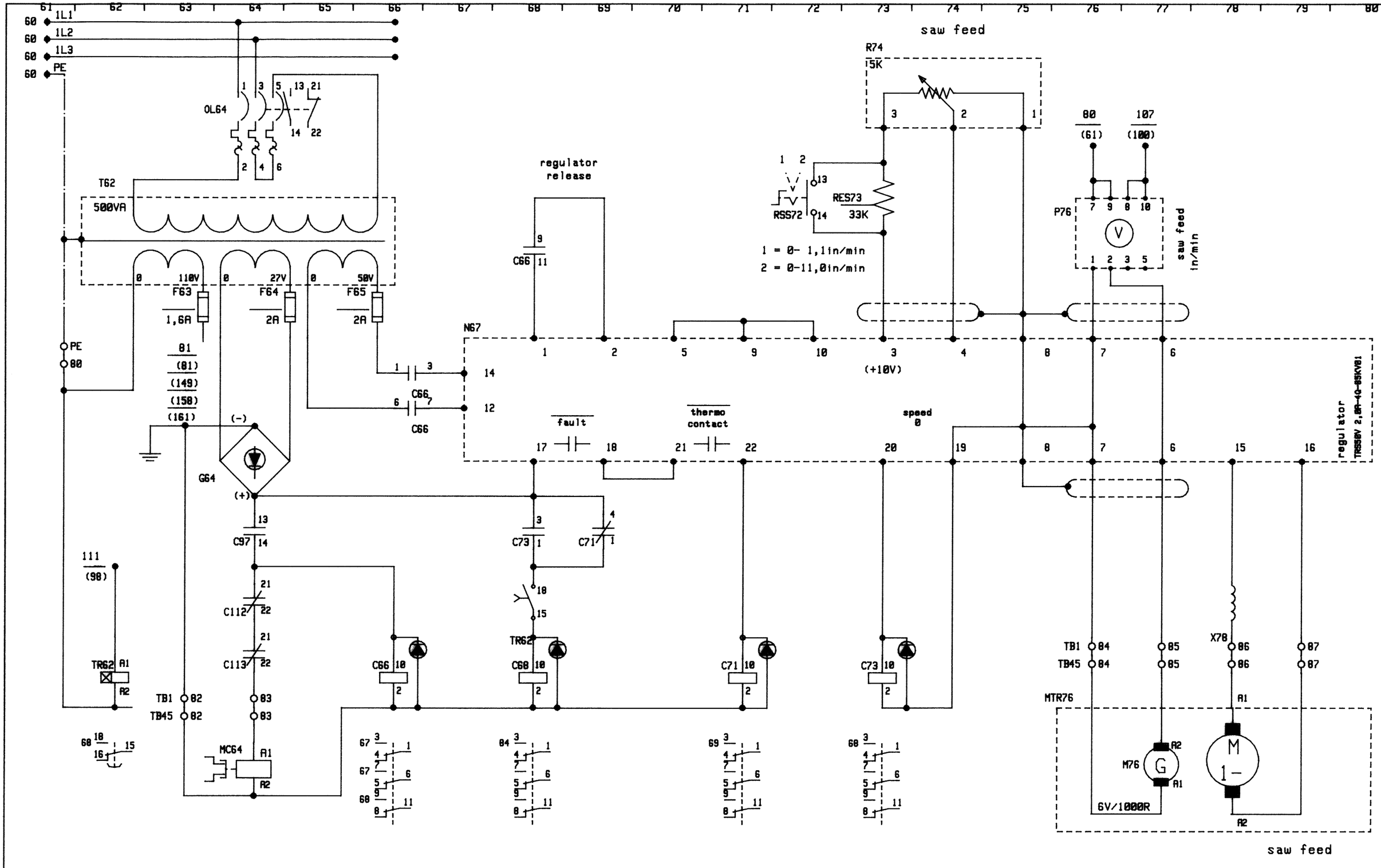
41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60

40 1L1 — 1L1 61
40 1L2 — 1L2 61
40 1L3 — 1L3 61
40 N — N 61
40 PE — PE 61



KASTO Maschinenbau GmbH & Co KG		Datum	Name	Benennung:	Kunde "Standard"	Blätter 13
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gez.	12.12.91	HÖROLD	BBS 560/1060 220/440V,60Hz "e067"	Zeichnungs-Nr. 1485229 0989 106	Blatt 3
	gepr.					
	Norm.					

899 038



KASTO Maschinenbau GmbH & Co. KG		Datum	Name	Benennung:	Kunde	Blätter
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gez.	23.09.89	OSCHLIES	BBS 560/1060 220/440V,60Hz "e067"	"Standard"	13
	gepr.				Zeichnungs-Nr. 1485229 0989 106	Blatt 4
	Norm.					

899 046

Wöhrle Rastatt 48-1730

81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100

63 81 110V 11

emergency off ES82 12

TB1 100

RP81.1 TB3 100

emergency off RP82 ES82.1 RP82

TB3 101

emergency off RP83 ES82.2 RP83

TB3 102

RP81.3 TB1 102

emergency off RP205.1 ES205 RP205.3

TB1 103

transportable control panel

103 (104)

C84 51 52

C87 21 22

LT83

61 80

OL4 13 14

up to OL44 13 14

C68 4 1

C84 23 24

C97 24

C85 31 32

C87 32

TR86 13 14

C84 61 62

C84 A1 A2

C85 A1 A2

TR86 A1 A2

C87 A1 A2

C84 13 14

C104 21 22

D139 11 14

E PB87 21 22

sawing machine on

PB112 31 32

C97 33 34

C87 43 44

E PB89 21 22

TB1 109

TB89 109

P tension sawband PS89

TB89 110

TB89 110

wheel cover

LS89.1 1 2 -173

TB89 111

TB1 111

C119 21 22

C97 43 44

P163 8 9

RSS171 21 22

P144 4 5

PB112 43 44

saw + return PB93 21 22

13 14 (112)

107 101

170 101

111 (62) (108) (137)

C93 A1 A2

C96 A1 A2

C97 A1 A2

LT98

80 101

fault

control on

Hydr. free stroke

general switch-off

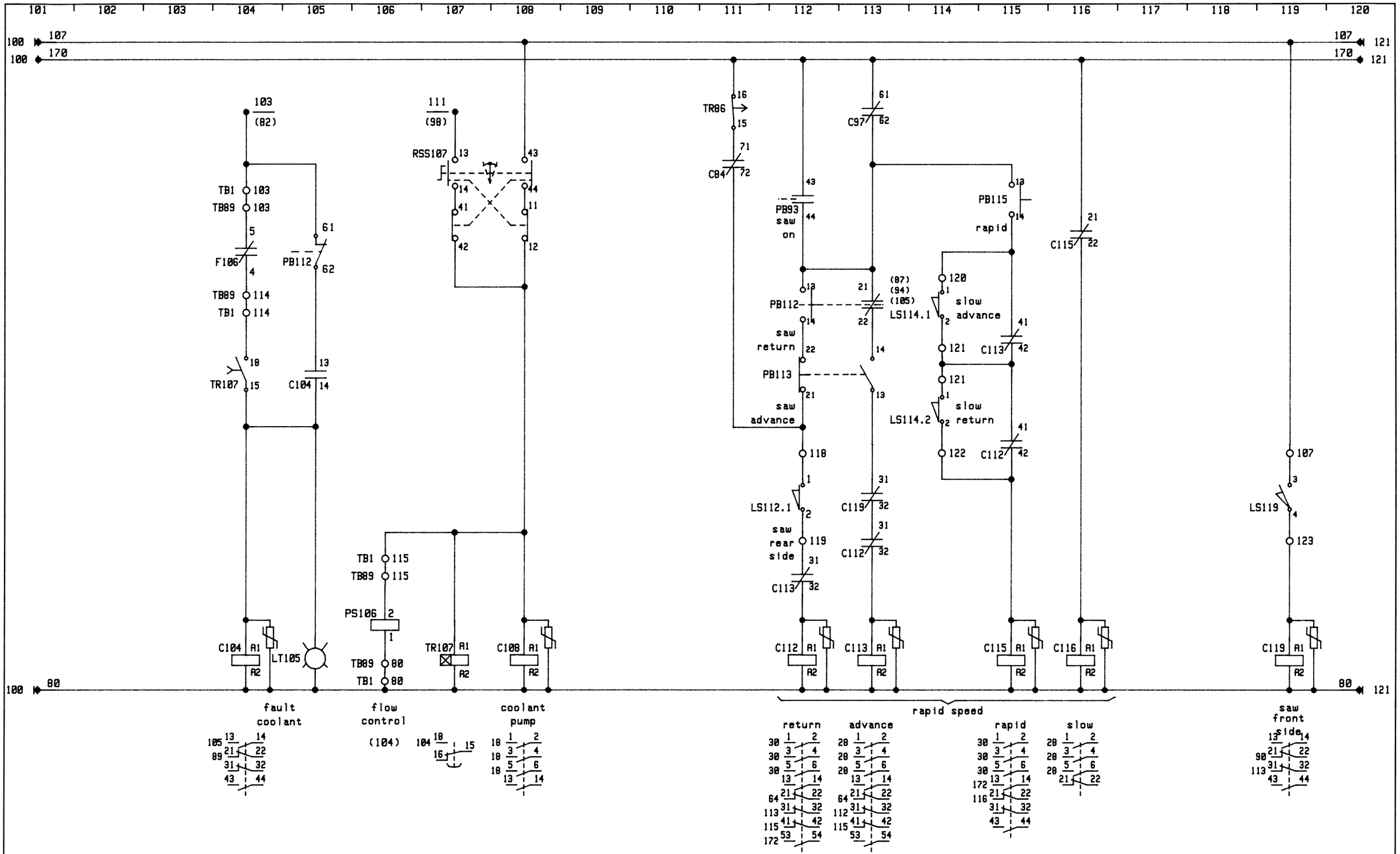
saw motor

sawing machine on

KASTO Maschinenbau GmbH & Co KG		Datum	Name	Benennung: BBS 560/1060 220/440V,60Hz "e067"	Kunde "Standard"	Blätter 13
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gez.	12.12.91	HÖROLD		Zeichnungs-Nr. 1485229 0989 106	Blatt 5
	gepr.					
	Norm.					

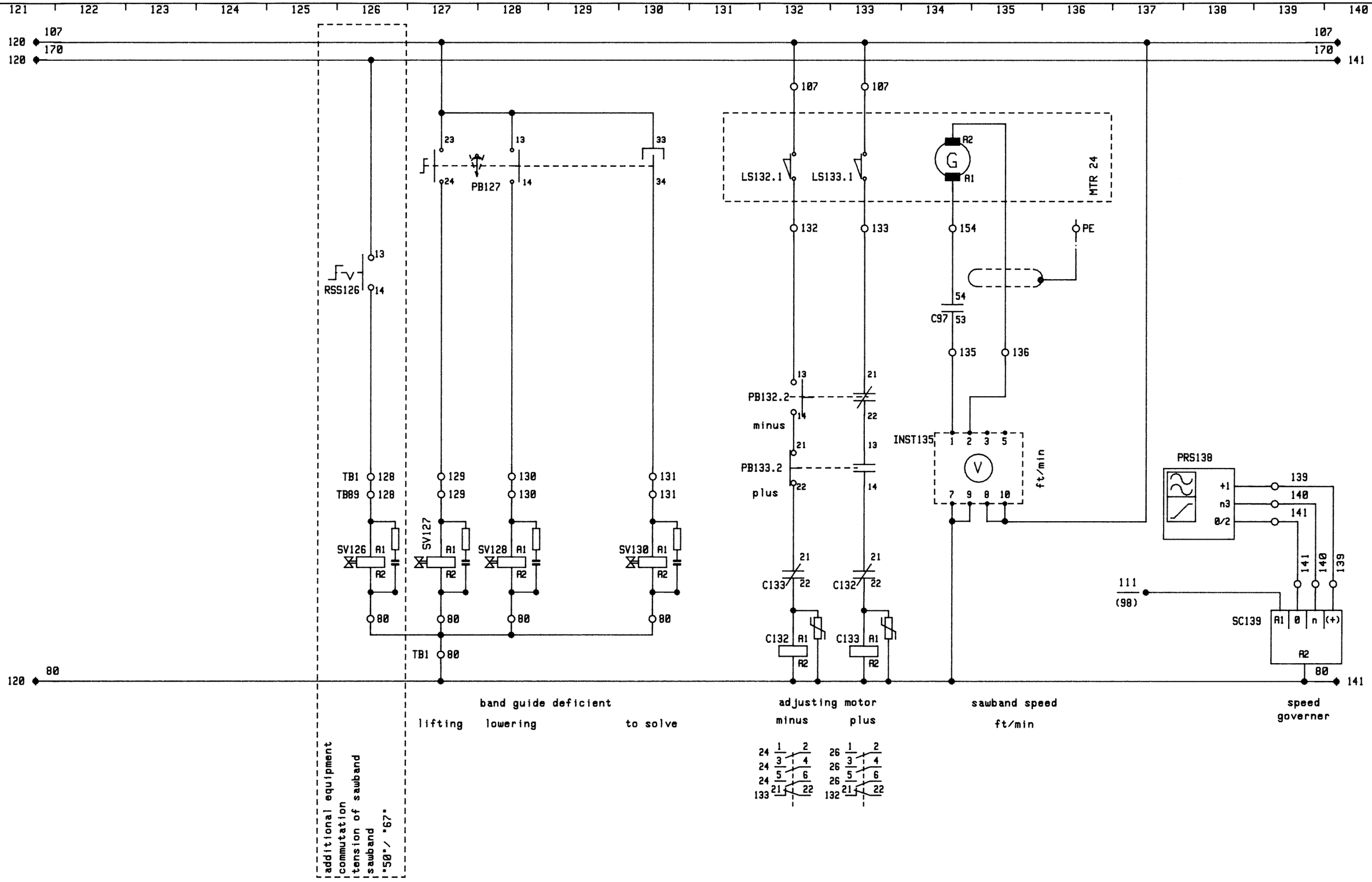
899 038

Wöhrle Rastatt



KASTO Maschinenbau GmbH & Co KG		Datum	Name	Benennung:	Kunde "Standard"	Blätter 13
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gez.	12.12.91	HÖROLD	BBS 560/1060 220/440V,60Hz "e067"	Zeichnungs-Nr. 1485229 0989 106	Blatt 6
	gepr.					
	Norm.					

899 038



KASTO Maschinenbau GmbH & Co KG		Datum	Name	Benennung: BBS 560/1060 220/440V,60Hz "e067"	Kunde "Standard" / Blätter 13
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gez.	12.12.91	HÖROLD		Zeichnungs-Nr. 1485229 0989 106 / Blatt 7
	gepr.				
	Norm.				

899 038

Wöhrle Rastatt 11-0887

141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160

140 170 — 170 181

RSS142 13 14

PRS144

pulse transmitter

A B (+) (-)

P142

3 1 13 14 10 9 8

coding switch
ON, 9,10,12,14

2 1 4 5 11 12

(93)

PE

81
(63)

TCS149

1 3 4

18W

M
1~

MTR149

KS151 13 14

150

RP151

RP151.1

NTL151

RP151.1

RP151.

151

23

KS151 24

3

1L1 1L2 1L3

OL155 1 3 5 2 4 6

C158 1 3 5 2 4 6

152 153

RP12

TB3 152 153

RP153

E153

HEIZUNG

TB3 152 153

RP155

E155

HEIZUNG

81
(63)

PB158 13 14

C158 A1 A2 LT159

155 1 2
155 3 4
155 5 6
155 21 22

80 140 — 80 161

counter
Depth
adjustment

switch cupboard
ventilator

additional equipment
laser

additional equipment
heating
coolant

		Datum	Name
KASTO Maschinenbau GmbH & Co KG	gez.	12.12.91	HÖROLD
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gepr.		
	Norm.		

Benennung: BBS 560/1060
220/440V,60Hz "e067"

Kunde "Standard"

Zeichnungs-Nr. 1485229 0989 106

Blätter 13

Blatt 8

899 038

Wöhrle Rastatt

161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180

63 81 — 81 181

P163

ST 1

0.5Amt

NETZ

PE

70% VW

VW

+24V

(175)

(92)

13 C171 14

RSS171 13 14 93

83 C97 84

13 C115 14

53 C112 54

160

3 LS89.1 wheel cover 4

161

6 P163 7

43 C171 44

21 C175 22

162

NTL176

ST 2

B169

+24V
0V

+24V
0V
A

band control

C171 A1 A2 E1 E2

C175 A1 A2

160 80 — 80 181

169 13 14 21 22 31 32 176 43 44

176 13 14 21 22 31 32 43 44

additional equipment
band control

additional equipment
flashlight
70% band development

		Datum	Name
KASTO Maschinenbau GmbH & Co. KG	gez.	23.09.89	OSCHLIES
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gepr.		
	Norm.		

Benennung: BBS 560/1060
220/440V,60Hz "e067"

Kunde "Standard"

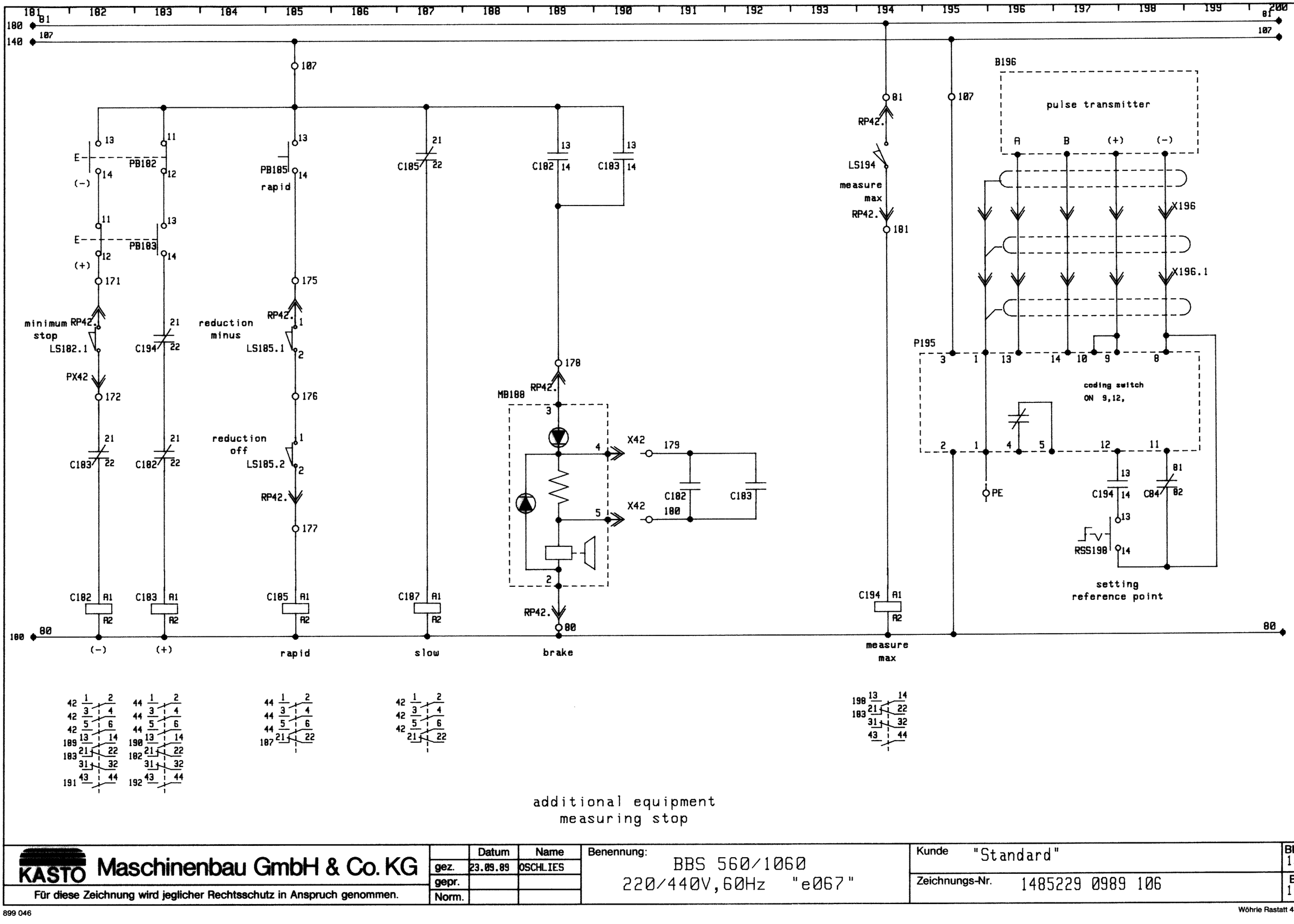
Zeichnungs-Nr. 1485229 0989 106

Blätter 13

Blatt 9

899 046

Wöhrle Rastatt 48-1730



(-) (+) rapid slow brake measure max

additional equipment
measuring stop

KASTO Maschinenbau GmbH & Co. KG		Datum	Name	Benennung:	Kunde	Blätter
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gez.	23.09.89	OSCHLIES	BBS 560/1060 220/440V,60Hz "e067"	"Standard"	13
	gepr.				Zeichnungs-Nr. 1485229 0989 106	Blatt 10
	Norm.					

899 046

Wöhrle Rastatt 48-1730

201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220

control panel transportable

ES205 11 12

13 14 RSS208 23 24 176

13 14 RSS210 23 24 177

13 14 RSS212 23 24 178

13 14 RSS214 23 24 179

RSS208 RSS210 RSS212 RSS214

e 221

f 234

RP205. 1 2 3 4 5 6 7 8 9 10 11 12

TB1 103 102 107 190 191 192 193 194 195 196 197 198

190 191 192 193 194 195 196 197

switchcabinet

80

RP81.

TB3 80 190 191 192 193 194 195 196 197

RP36.4 5 6 7 8 9 10 11 12

TB37 80 190 191 192 193 194 195 196 197

SV208 A1 A2 80 SV209 A1 A2 80 SV210 A1 A2 80 SV211 A1 A2 80 SV212 A1 A2 80 SV213 A1 A2 80 SV214 A1 A2 80 SV215 A1 A2 80

80 221

I

roller rail lifting

lowering

advance

return

II

roller rail lifting

lowering

advance

return

additional equipment

C218 A1 A2

80 80

63

Hydr. aggregate

36 1 2
36 3 4
36 5 6
21 22

KASTO Maschinenbau GmbH & Co. KG		Datum	Name	Benennung: BBS 560/1060 220/440V,60Hz "e067"	Kunde "Standard" / Blätter 13
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	gez.	23.09.89	OSCHLIES		Zeichnungs-Nr. 1485229 0989 106 / Blatt 11
	gepr.				
	Norm.				

899 046

Wöhrle Rastatt 48-1730

221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240

control panel transportable

179 e

13 23 195 14 RSS222 24

13 23 196 14 RSS224 24

13 23 197 14 RSS226 24

13 23 198 14 RSS228 24

RSS222 RSS224 RSS226 RSS228

219 f

RP205 13 14 15 16 17 18 19 20

switchcabinet

TB1 199 200 201 202 203 204 205 206

199 200 201 202 203 204 205 206

RP81. 13 14 15 16 17 18 19 20

TB3 199 200 201 202 203 204 205 206

RP36.13 14 15 16 17 18 19 20

TB37 199 200 201 202 203 204 205 206

SV222 A1 A2 SV223 A1 A2 SV224 A1 A2 SV225 A1 A2 SV226 A1 A2 SV227 A1 A2 SV228 A1 A2 SV229 A1 A2

216 80 80 80 80 80 80 80 80 80 80 80

III IV

roller rail lifting

lowering

advance

return

roller rail lifting

lowering

advance

return

additional equipment

KASTO Maschinenbau GmbH & Co. KG		Datum	Name	Benennung:	Kunde "Standard"	Blätter 13
	gez.	23.09.89	OSCHLIES	BBS 560/1060 220/440V,60Hz "e067"		
	gepr.				Zeichnungs-Nr. 1485229 0989 106	Blatt 12
Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.	Norm.					

Wöhrle Rastatt 48-1730

241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260

3 1L1
3 1L2
3 1L3

FU243 16A

impulse

C259 1 3 5 / 2 4 6

LT244

magnetized

LT256

13 23 14 RSS252 24

140 80 140 107

TB1 220 221 222 223 224 225 226 107 227 80

RP81.

TB3 220 221 222 223 224 225 226 107 227

RP36

TB37 PE 220 221 222 223 224 225 226 107 227

RP243.

TB244 PE L1 L2 3 4 23 9 11 16 18

220/380/420V 0 L2

T249 30VA 16V 0V 0V 8V 24V

N241

blue

TB247 1 12 4 6 2 3 7 8 5 9 11 10 15 16 18 14

black

TB245 1 2 3 4 5 6

control
MT 1500

8,2K/10W

8200uF200V

8,2K/10W

8200uF200V

drops at magnet 3

drops at magnet 4

switchcabinet
clamp.magnets

RP248.1 2 4 3 E248 magnet 1

RP250.1 2 3 4 E250 magnet 2

RP252.1 2 4 3 E252 magnet 3

RP254.1 2 3 4 E254 magnet 4

C259 A1 A2

243 1 2
243 3 4
243 5 6
13 14

additional equipment
clamp.magnets

machine switchcabinet

KASTO Maschinenbau GmbH & Co KG

Für diese Zeichnung wird jeglicher Rechtsschutz in Anspruch genommen.

	Datum	Name
gez.	23.09.89	OSCHLIES
gepr.		
Norm.		

Benennung:
BBS 560/1060
220/440V,60Hz "e067"

Kunde "Standard"

Zeichnungs-Nr. 1485229 0989 106

Blätter 13

Blatt 13

Wöhrle Rastatt 49-1440

w o r k i n g s t o c k - l i s t

drawing No. : 1485229 0989 106
customer : "Standard"
denomination : BBS 560/1060Ø220/440V,60Hz "eØ67"
name : HÖROLD
date : 12.12.91 page : 1

device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
A36	AH-00803243	hydraulic aggregate MP44A-Z5,2-B25-A51/120, 2.2KW 220-250/380-460V,50/60Hz, 9.7/5.6A	HAWE
B169	BI-00782149	analog initiator BIS-M18-LU 0-10V Sn Ø-2mm BEST.-NR. 15362	TURCK
B196	BD-00968722	momentum generator TYP. 10-11231-50 50 Imp/Umdr. Axial-Kabelausgang	KÜBLER
C66	KR-00384038	industrial relay 3 changer UF 3G 24V DC,N GOLDKONTAKT	KUHNKE
C68	KR-00280119	industrial relay 3 changer UF 3 24V DC, N NORMALKONTAKT	KUHNKE
C71	KR-00280119	industrial relay 3 changer UF 3 24V DC, N NORMALKONTAKT	KUHNKE
C73	KR-00280119	industrial relay 3 changer UF 3 24V DC, N NORMALKONTAKT	KUHNKE
C84	KH-00105678	contactor relay PH 44E 4S-4Ö 110V 50/60HZ	STARKSTROM
C85	KM-00281204	motor relay 4KW PD 2 Ø1 E, 1Ö, 110V 50/60Hz	STARKSTROM
C87	KH-00281220	contactor relay PH 22E 2S-SÖ 110V 50/60Hz	STARKSTROM
C93	KM-00338621	motor relay 11KW PE 5 22 E, 2S-2Ö, 110V 50/60Hz	STARKSTROM
C96	KM-00281204	motor relay 4KW PD 2 Ø1 E, 1Ö, 110V 50/60Hz	STARKSTROM
C97	KH-00105694	contactor relay PH 62E 6S-2Ö 110V 50/60Hz	STARKSTROM
C104	KH-00281220	contactor relay PH 22E 2S-SÖ 110V 50/60Hz	STARKSTROM
C108	KM-00281298	motor relay 4KW PD 2 10 E, 1S, 110V 50/60Hz	STARKSTROM
C112	KM-00105651	motor relay 4KW PD 2 23 E, 2S-3Ö, 110V 50/60Hz	STARKSTROM

w o r k i n g s t o c k - l i s t

drawing No. : 1485229 0989 106
customer : "Standard"
denomination : BBS 560/1060@220/440V,60Hz "e067"
name : HÖROLD
date : 12.12.91 page : 2

device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
C113	KM-00105651	motor relay 4KW PD 2 23 E, 2S-3Ö, 110V 50/60Hz	STARKSTROM
C115	KM-00105643	motor relay 4KW PD 2 32 E, 3S-2Ö, 110V 50/60Hz	STARKSTROM
C116	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM
C119	KH-00281220	contactor relay PH 22E 2S-SÖ 110V 50/60Hz	STARKSTROM
C132	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM
C133	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM
C158	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM
C171	KH-00281220	contactor relay PH 22E 2S-SÖ 110V 50/60Hz	STARKSTROM
C171	KA-00797650	modul PLA 110V,50/60Hz	STARKSTROM
C175	KH-00281220	contactor relay PH 22E 2S-SÖ 110V 50/60Hz	STARKSTROM
C182	KM-00105643	motor relay 4KW PD 2 32 E, 3S-2Ö, 110V 50/60Hz	STARKSTROM
C183	KM-00105643	motor relay 4KW PD 2 32 E, 3S-2Ö, 110V 50/60Hz	STARKSTROM
C185	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM
C187	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM
C194	KH-00281220	contactor relay PH 22E 2S-SÖ 110V 50/60Hz	STARKSTROM
C218	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM
C218	KM-00281204	motor relay 4KW PD 2 01 E, 1Ö, 110V 50/60Hz	STARKSTROM

w o r k i n g s t o c k - l i s t

drawing No. : 1485229 0989 106
customer : "Standard"
denomination : BBS 560/10600220/440V,60Hz "e067"
name : HÖROLD
date : 12.12.91 page : 3

device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
*C259	KM-00281298	motor relay 4KW PD 2 10 E, 1S, 110V 50/60Hz	STARKSTROM
DS2	QH-00880558	main-switch KG64 B, K300/D-A011E, AC3, 63A 11KW bei 220V, 18.5KW bei 380V bis 660V	KRAUS&NAIMER
E153	TEXT0000013	at 220V/60Hz	
E153	EH-00652504	dip-heater with thermostat C/TH R1 1/2" Edelstahlausführung 220V, 1.5KW, IP65, 400mm	HELIOS
(E153)	TEXT0000020	at 440V/60Hz	
(E153)	EH-00796077	dip-heater with thermostat C/TH R1 1/2" Edelstahlausführung 440V, 1.5KW, IP65, 400mm	HELIOS
E155	TEXT0000013	at 220V/60Hz	
E155	EH-00652504	dip-heater with thermostat C/TH R1 1/2" Edelstahlausführung 220V, 1.5KW, IP65, 400mm	HELIOS
(E155)	TEXT0000020	at 440V/60Hz	
(E155)	EH-00796077	dip-heater with thermostat C/TH R1 1/2" Edelstahlausführung 440V, 1.5KW, IP65, 400mm	HELIOS
*E248	EE-01022539	electromagnets Typ. QS-230 K 1 230 x 330 x 98 mm kABEL 8 m	GÜHRING
*E250	EE-01022547	electromagnets Typ. QS 230 K 2 230 x 330 x 128 mm Kabel 8m	GÜHRING
*E252	EE-01022547	electromagnets Typ. QS 230 K 2 230 x 330 x 128 mm Kabel 8m	GÜHRING
*E254	EE-01022539	electromagnets Typ. QS-230 K 1 230 x 330 x 98 mm kABEL 8 m	GÜHRING

w o r k i n g s t o c k - l i s t

drawing No. : 1485229 0989 106
customer : "Standard"
denomination : BBS 560/1060@220/440V,60Hz "e067"
name : HÖROLD
date : 12.12.91 page : 4

device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
ES82	SD-00280313	mushroom button 3SB1000-1AC01 Not-Aus	SIEMENS
ES82	SO-00268321	control element 3SB1300-0C SOCKEL MIT 1ÖFFNER	SIEMENS
ES82	SZ-00248304	spacer sign yellow for emer.-off 	SIEMENS
ES82.1	SD-00317527	mushroom button 3SB1801-7AM Not-Aus Komplett mit Gehäuse (Aufbau)	SIEMENS
ES82.2	SD-00317527	mushroom button 3SB1801-7AM Not-Aus Komplett mit Gehäuse (Aufbau)	SIEMENS
ES205	SD-00280313	mushroom button 3SB1000-1AC01 Not-Aus	SIEMENS
ES205	SO-00268321	control element 3SB1300-0C SOCKEL MIT 1ÖFFNER	SIEMENS
ES205	SZ-00248304	spacer sign yellow for emer.-off 	SIEMENS
G64	GW-00293873	bridge rectifier KB60-B250/220-10	HERRMANN
INST135	PV-00974048	indication device HDV 4100-05, 4 1/2-stellig 110/220V AC, Eingangsspannung DC	HORN
INST135	PV-00973939	indication plate ft/min für HDV 4100-05	HORN
KS151	SO-00345717	key button 3SB1000-4LA01 VERRASTEND 0-1, Schlüssel SSG 10	SIEMENS
KS151	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
KS151	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
LS89.1	SE-00813451	limit switch AZ 16ZVR MIT BÜGEL ZUR ZWANGSÖFFNUNG	SCHMERSAL
LS112.1	SE-00335355	limit switch ENK SU1/AH ACHSHEBEL FORM A	BERNSTEIN

w o r k i n g s t o c k - l i s t

drawing No. : 1485229 0989 106
customer : "Standard"
denomination : BBS 560/1060@220/440V,60Hz "e067"
name : HÖROLD
date : 12.12.91 page : 5

device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
LS114.1	SE-00335355	limit switch ENK SU1/AH ACHSHEBEL FORM A	BERNSTEIN
LS114.2	SE-00335355	limit switch ENK SU1/AH ACHSHEBEL FORM A	BERNSTEIN
LS119	SE-00335355	limit switch ENK SU1/AH ACHSHEBEL FORM A	BERNSTEIN
LS132.1	TEXT0000210	micro-sw.in adjus.eng.tape speed GETRIEBE BANDGESCHWINDIGKEIT	
LS133.1	TEXT0000210	micro-sw.in adjus.eng.tape speed GETRIEBE BANDGESCHWINDIGKEIT	
LS182.1	SE-00968811	limit switch 3SE3 100-1D ROLLENSTÖßEL	SIEMENS
LS185.1	SE-00968811	limit switch 3SE3 100-1D ROLLENSTÖßEL	SIEMENS
LS185.2	SE-00968811	limit switch 3SE3 100-1D ROLLENSTÖßEL	SIEMENS
LS194	SE-00968811	limit switch 3SE3 100-1D ROLLENSTÖßEL	SIEMENS
LT83	HM-00280429	luminous register adapter red 3SB1001-6BC06	SIEMENS
LT83	HO-00280399	socket with holder 3SB1300-2A	SIEMENS
LT83	HÜ-00276820	filamant bulb B9S 130V	SIEMENS
LT98	HÜ-00276820	filamant bulb B9S 130V	SIEMENS
LT105	HM-00280429	luminous register adapter red 3SB1001-6BC06	SIEMENS
LT105	HO-00280399	socket with holder 3SB1300-2A	SIEMENS
LT105	HÜ-00276820	filamant bulb B9S 130V	SIEMENS
*LT159	HM-00293148	luminous register adapter white 3SB1001-6BG06	SIEMENS

w o r k i n g s t o c k - l i s t

drawing No. : 1485229 0989 106
customer : "Standard"
denomination : BBS 560/1060@220/440V,60Hz "e067"
name : HÖROLD
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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
*LT159	HO-00280399	socket with holder 3SB1300-2A	SIEMENS
*LT159	HÜ-00276820	filamant bulb B9S 130V	SIEMENS
*LT246	HO-00280399	socket with holder 3SB1300-2A	SIEMENS
*LT246	HM-00293148	luminous register adapter white 3SB1001-6B606	SIEMENS
*LT246	HI-00169169	glow lamp BA9S 110V	SIEMENS
*LT244	HI-01396471	glow lamp 3SB1902-2AB mit BI-PIN-ANSCHLUSS	SIEMENS
MTR4	MD-00879134	motor threeph.curr.220/440V,60Hz 132MR F7,S/4-7S B5 7,5KW,FL.300 32,0/16,0A	BAUKNECHT
MTR76	MG-00878472	motor direct curr. Typ: RT220 + TB206 + PL652 I=1:20,25 NAB 106.7	SAT
MTR10	MD-00968498	motor threeph.curr.220/440V,60Hz 63/8F, 0,09KW, 1,1/0,55A 750U/min, B14/90,IP54	BAUKNECHT
MTR12	MR-00465046	motor with gear 220/440V,60Hz R40DT71 K4, 0,15KW, 1,3/0,65A 19 U/Min, B3	SEW
*MTR14	MS-00329517	chip conveyor CF10 M 1B 4U, 0.06KW, Welle 18mm 220/440V 60Hz, UL-CSA, 0.35/0.2A	FLENDER + HIMMEL
*MTR16	MK-00271896	coolant pump TB25/170 220-250/380-440V, 50/60Hz 0.38/0.22A, 0.10KW, 30 l/min.	BRINKMANN
MTR18	MK-00904643	coolant pump T11.2/190 220V/440V, 60Hz 1.2A, 0.7A, 0.37KW, 12 l/min.	BRINKMANN
MTR22	MD-00173339	motor threeph.curr.220/440V,60Hz 71L-4F, 0.37KW, 2.5/1.25A 1600U/MIN, B14/140	HUBER + MOSER

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
MTR24	MR-00879142	motor with gear servo-adjustment TYP.11.330.25.933,CSA, 0,075KW 220/440V , 60Hz, 0,54/0,27A	LENZE
MTR29	TEXT0000013	at 220V/60Hz	
MTR29	MR-00878723	motor with gear 220V/60Hz KF66 DT80N 8/2, 0.12/0.48KW 6/26U/min., 1.55/2.6A, B5IIIA	SEW
(MTR29)	TEXT0000020	at 440V/60Hz	
(MTR29)	MR-00879215	motor with gear 440V/60Hz KF66 DT80K 8/2, 0.12/0.48KW 6/26U/min., 0.76/1.3A, B5IIIA	SEW
MTR43/Y189	TEXT0000013	at 220V/60Hz	
MTR43/Y189	MD-00878774	motor threeph.curr. 220V/60Hz 71R 0,37/8/4-7 0,15/0,22KW,B14,FL105,0,87/2,5A	BAUKNECHT
MTR43/Y189	TEXT0000020	at 440V/60Hz	
MTR43/Y189	MD-00573256	motor with brake 440V,60Hz 71L-12/2GBR, 0,03/0,15KW, 0,36/0,6A 550/3360U/min, B14, FL.Ø105	HUBER + MOSER
MTR149	ML-00764396	switch cabinet ventilator 18W FLF ØD 115 V	PFANNENBERG
MTR149	ML-00315036	vent filter AFFØ mit Filtermatte	PFANNENBERG
N67	NG-00878480	speed contr.device TSR 50V / 2,0A - 4Q / K-85 V01	SAT
NTL151	EL-00973602	NE HE@LASER 110V AC Ausgangsleistung 5MW/min.	LAP
NTL176	HW-00798029	warning- and flash lamp ABL ROT 110V AC	PFANNENBERG
*N241	NU-01022555	pole reversal units Typ. MT 1500 200-440V, AC	GÜHRING

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
OL4	TEXT0000013	at 220V/60Hz	
OL4	QM-00363324	motor protector switch 3VE 4200-1CR00 28-40A mit Hilfskontakten 1S/1Ö	SIEMENS
OL4	QM-00243019	auxilaire switch 3VE 9301-1AA00 für 3VE3000, + 3VE4200,	SIEMENS
(OL4)	TEXT0000020	at 440V/60Hz	
(OL4)	QM-00335053	motor protector switch 3VU 1300-1MN00 14-20A	SIEMENS
OL9	TEXT0000013	at 220V/60Hz	
OL9	QM-00243000	motor protector switch 3VU 1300-1MP00 18-25A	SIEMENS
(OL9)	TEXT0000020	at 440V/60Hz	
(OL9)	QM-00243000	motor protector switch 3VU 1300-1MP00 18-25A	SIEMENS
OL10	TEXT0000013	at 220V/60Hz	
OL10	QM-00175072	motor protector switch 3VU 1300-1MG00 1-1,6A	SIEMENS
(OL10)	TEXT0000020	at 440V/60Hz	
(OL10)	QM-00175064	motor protector switch 3VU 1300-1MF00 0,6-1A	SIEMENS
OL12	TEXT0000013	at 220V/60Hz	
OL12	QM-00175072	motor protector switch 3VU 1300-1MG00 1-1,6A	SIEMENS
(OL12)	TEXT0000020	at 440V/60Hz	

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
(OL12)	QM-00175064	motor protector switch 3VU 1300-1MF00 0,6-1A	SIEMENS
OL14	TEXT0000013	at 220V/60Hz	
OL14	QM-00175056	motor protector switch 3VU 1300-1ME00 0,4-0,6A	SIEMENS
(OL14)	TEXT0000020	at 440V/60Hz	
(OL14)	QM-00175048	motor protector switch 3VU 1300-1MD00 0,24-0,4A	SIEMENS
OL16	TEXT0000013	at 220V/60Hz	
OL16	QM-00175056	motor protector switch 3VU 1300-1ME00 0,4-0,6A	SIEMENS
(OL16)	TEXT0000020	at 440V/60Hz	
(OL16)	QM-00175048	motor protector switch 3VU 1300-1MD00 0,24-0,4A	SIEMENS
OL18	TEXT0000013	at 220V/60Hz	
OL18	QM-00175072	motor protector switch 3VU 1300-1MG00 1-1,6A	SIEMENS
(OL18)	TEXT0000020	at 440V/60Hz	
(OL18)	QM-00175064	motor protector switch 3VU 1300-1MF00 0,6-1A	SIEMENS
OL22	TEXT0000013	at 220V/60Hz	
OL22	QM-00175099	motor protector switch 3VU 1300-1MJ00 2,4-4A	SIEMENS
(OL22)	TEXT0000020	at 440V/60Hz	
(OL22)	QM-00175072	motor protector switch 3VU 1300-1MG00 1-1,6A	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
OL24	TEXT0000013	at 220V/60Hz	
OL24	QM-00175056	motor protector switch 3VU 1300-1ME00 0,4-0,6A	SIEMENS
(OL24)	TEXT0000020	at 440V/60Hz	
(OL24)	QM-00175021	motor protector switch 3VU 1300-1MC00 0,16-0,24A	SIEMENS
OL28	TEXT0000013	at 220V/60Hz	
OL28	QM-00175080	motor protector switch 3VU 1300-1MH00 1,6-2,4A	SIEMENS
(OL28)	TEXT0000020	at 440V/60Hz	
(OL28)	QM-00175072	motor protector switch 3VU 1300-1MG00 1-1,6A	SIEMENS
OL30	TEXT0000013	at 220V/60Hz	
OL30	QM-00175099	motor protector switch 3VU 1300-1MJ00 2,4-4A	SIEMENS
(OL30)	TEXT0000020	at 440V/60Hz	
(OL30)	QM-00175080	motor protector switch 3VU 1300-1MH00 1,6-2,4A	SIEMENS
OL36	TEXT0000013	at 220V/60Hz	
OL36	QM-00175110	motor protector switch 3VU 1300-1ML00 6-10A	SIEMENS
(OL36)	TEXT0000020	at 440V/60Hz	
(OL36)	QM-00175102	motor protector switch 3VU 1300-1MK00 4-6A	SIEMENS
OL42	TEXT0000013	at 220V/60Hz	

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
OL42	QM-00175072	motor protector switch 3VU 1300-1MG00 1-1,6A	SIEMENS
(OL42)	TEXT0000020	at 440V/60Hz	
(OL42)	QM-00175064	motor protector switch 3VU 1300-1MF00 0,6-1A	SIEMENS
OL44	TEXT0000013	at 220V/60Hz	
OL44	QM-00175099	motor protector switch 3VU 1300-1MJ00 2,4-4A	SIEMENS
(OL44)	TEXT0000020	at 440V/60Hz	
(OL44)	QM-00175072	motor protector switch 3VU 1300-1MG00 1-1,6A	SIEMENS
OL64	TEXT0000013	at 220V/60Hz	
OL64	QM-00175080	motor protector switch 3VU 1300-1MH00 1,6-2,4A	SIEMENS
(OL64)	TEXT0000020	at 440V/60Hz	
(OL64)	QM-00175080	motor protector switch 3VU 1300-1MH00 1,6-2,4A	SIEMENS
*OL155	TEXT0000013	at 220V/60Hz	
OL155	QM-00335053	motor protector switch 3VU 1300-1MN00 14-20A	SIEMENS
(OL155)	TEXT0000020	at 440V/60Hz	
(OL155)	QM-00335053	motor protector switch 3VU 1300-1MN00 14-20A	SIEMENS
OL243	TEXT0000013	at 220V/60Hz	
OL243	QM-00335053	motor protector switch 3VU 1300-1MN00 14-20A	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
(OL243)	TEXT0000020	at 440V/60Hz	
(OL243)	QM-00335053	motor protector switch 3VU 1300-1MN00 14-20A	SIEMENS
P76	PV-00974048	indication device HDV 4100-05, 4 1/2-stellig 110/220V AC, Eingangsspannung DC	HORN
P76	PV-00973955	indication plate in/min für HDV 4100-05	HORN
P142	PI-01396745	preselection counter electronic Typ. NE 625.31BX3XA, 110V AC 6-stellig, LED-13mm,	IRION&VOSSELER
P163	PÜ-00782157	running control device 110V/50-60Hz 96 * 96 * 180 mm	SÜTRON
P163	PÜ-00681512	cover cap Nr. 446-040-01 für 96 * 96 Geräte	APRANORM
P195	PI-01396745	preselection counter electronic Typ. NE 625.31BX3XA, 110V AC 6-stellig, LED-13mm,	IRION&VOSSELER
PB87	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS
PB87	SZ-00268364	control element 3SB1400-0A 1SCHLIEßER + 1ÖFFNER	SIEMENS
PB87	SZ-00268410	inlayplates "-" 3SB1901-4NH	SIEMENS
PB89	SD-00280291	pressure button 3SB1000-0AW01 rot Beschriftung 0	SIEMENS
PB89	SO-00268321	control element 3SB1300-0C SOCKEL MIT 1ÖFFNER	SIEMENS
PB93	SD-00280305	pressure button 3SB1000-0AB01 schwarz	SIEMENS
PB93	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
PB93	SZ-00268364	control element 3SB1400-0A 1SCHLIEßER + 1ÖFFNER	SIEMENS
PB112	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS
PB112	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
PB112	SZ-00284610	inlayplates -arrow- 3SB1901-4NA	SIEMENS
PB112	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
PB113	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS
PB115	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
PB127	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
PB127	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
PB127	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
PB127	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
PB127	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
PB127	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
PB132.2	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS
PB132.2	SZ-00268410	inlayplates "-" 3SB1901-4NH	SIEMENS
PB132.2	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
PB133.2	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
PB133.2	SZ-00268402	inlayplates "+" 3SB1901-4NG	SIEMENS
PB133.2	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
PB158	SW-00280356	turning lever 3SB1000-3AB01 0-I VERRASTEND	SIEMENS
PB158	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
PB182	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS
PB182	SZ-00268410	inlayplates "-" 3SB1901-4NH	SIEMENS
PB182	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
PB183	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS
PB183	SZ-00268402	inlayplates "+" 3SB1901-4NG	SIEMENS
PB183	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
PB185	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
PB185	SZ-00307866	inlayplates (~) rapid speed 3SB1901-4NE	SIEMENS
PB185	SD-00268305	pressure button 3SB1000-0AH01 klar	SIEMENS
PRS138	BI-00337854	initiator KL-1822/010 Induktiv Öffner oder Schließer M30x1.5, 10-30V/DC, bündig einbaubar	BERNSTEIN
PRS144	BD-00905674	momentum generator Typ. 8.5800.1234.0200 200 Imp/Umdr. Axial-Kabelausgang	KÜBLER
PS89	FD-00247081	pressure switch NR. 9054 10-100BAR	SUCO

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
PS106	FD-01485040	flow controller Typ DF 2,6-WM-I-R3/8"-110V,AC 0,3-2,5l/min	KOBOLD
R74	RD-00930474	10 gear potentiometer Typ. AC10 / 5 KOHM	MEGATRON
R74	RD-00930466	adjusting knob FÜR 10-GANG-POTI NR.RD-00930474 mit Skala und Feststeller	MEGATRON
RES73	RF-00000005	resistor 33 KOHM	OSER
RP11	XS-00271527	soduts (black) CO516/5H bis 660V	ELEKTRA
RP11	XS-00271519	plugs (black) CT516/5H bis 660V	ELEKTRA
RP12	XS-00316520	mounted shell H-B16Sgrl Nr.10.0750	CONTACT
RP12	XS-00094250	socket insert H-BE 16B Nr.10.1951, 16polig (1-16)	CONTACT
RP12	XS-00316539	plugs shell H-B16Ts21 Nr.10.0820	CONTACT
RP12	XS-00094242	socket insert H-BE 16S Nr.10.1941, 16polig (1-16)	CONTACT
*RP14	XS-00364789	socket insert H-BE6B Nr.10.1911	CONTACT
*RP14	XS-00364746	bush shell H-B6Ts13 Nr.10.0120	CONTACT
*RP14	XS-00364770	socket insert H-BE6S Nr.10.1901	CONTACT
*RP14	XS-00076104	base shell HAN 3 HYE ASG 2-K3	HARTING
*RP36	XS-00316571	mounted shell HB24AG Nr.10.1020	CONTACT
*RP36	XS-00076058	socket insert H-BE 24BS Nr.10.1971, 24polig (1-24)	CONTACT
*RP36	XS-00316598	bush shell HB-24TS21 NR.10.1130	CONTACT

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
*RP36	XS-00076031	socket insert H-BE 24SS Nr.10.1961, 24polig (1-24)	CONTACT
RP81	XS-00316598	bush shell HB-24TS21 NR.10.1130	CONTACT
RP81	XS-00076058	socket insert H-BE 24BS Nr.10.1971, 24polig (1-24)	CONTACT
RP81	XS-00376604	mounted shell H-B48Sgr Nr.10.1680 mit Deckel, 2xPg29	CONTACT
RP81	XS-00076031	socket insert H-BE 24SS Nr.10.1961, 24polig (1-24)	CONTACT
RP82	XS-00096326	bush shell H-A3 TGV Nr.10.4250	CONTACT
RP82	XS-00096288	socket insert H-A3 BS Nr.10.4210 Kunststoff	CONTACT
RP82	XS-00096318	base shell H-A3Ags Nr.10.4230	CONTACT
RP82	XS-00096296	socket insert H-A 3 SS Nr.10.4200 Kunststoff	CONTACT
RP83	XS-00096326	bush shell H-A3 TGV Nr.10.4250	CONTACT
RP83	XS-00096288	socket insert H-A3 BS Nr.10.4210 Kunststoff	CONTACT
RP83	XS-00096318	base shell H-A3Ags Nr.10.4230	CONTACT
RP83	XS-00096296	socket insert H-A 3 SS Nr.10.4200 Kunststoff	CONTACT
*RP151	XS-00096318	base shell H-A3Ags Nr.10.4230	CONTACT
*RP151	XS-00096288	socket insert H-A3 BS Nr.10.4210 Kunststoff	CONTACT
*RP151	XS-00096326	bush shell H-A3 TGV Nr.10.4250	CONTACT
*RP151	XS-00096296	socket insert H-A 3 SS Nr.10.4200 Kunststoff	CONTACT

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
*RP153	XS-00364746	bush shell H-B6Ts13 Nr.10.0120	CONTACT
*RP153	XS-00364789	socket insert H-BE6B Nr.10.1911	CONTACT
*RP153	XS-00076104	base shell HAN 3 HYE ASG 2-K3	HARTING
*RP153	XS-00364770	socket insert H-BE6S Nr.10.1901	CONTACT
*RP155	XS-00364746	bush shell H-B6Ts13 Nr.10.0120	CONTACT
*RP155	XS-00364789	socket insert H-BE6B Nr.10.1911	CONTACT
*RP155	XS-00076104	base shell HAN 3 HYE ASG 2-K3	HARTING
*RP155	XS-00364770	socket insert H-BE6S Nr.10.1901	CONTACT
*RP205	XS-00316598	bush shell HB-24TS21 NR.10.1130	CONTACT
*RP205	XS-00076058	socket insert H-BE 24BS Nr.10.1971, 24polig (1-24)	CONTACT
*RP205	XS-00316571	mounted shell HB24AG Nr.10.1020	CONTACT
*RP205	XS-00076031	socket insert H-BE 24SS Nr.10.1961, 24polig (1-24)	CONTACT
*RP243	XS-00363820	mounted shell HB16 AD LB Nr.10.0739 (mit Deckel u. Längsbügel)	CONTACT
*RP243	XS-00316539	plugs shell H-B16Ts21 Nr.10.0820	CONTACT
*RP243	XS-00094250	socket insert H-BE 16B Nr.10.1951, 16polig (1-16)	CONTACT
*RP243	XS-00094242	socket insert H-BE 16S Nr.10.1941, 16polig (1-16)	CONTACT
RSS72	SW-00280356	turning lever 3SB1000-3AB01 0-I VERRASTEND	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
RSS72	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS108	SW-00275379	turning lever 3SB1000-3DB01 I-0-II VERRASTEND	SIEMENS
RSS108	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
RSS108	SZ-00695998	sign board "coolant pump" 3SB1900	SIEMENS
RSS108	SZ-00268364	control element 3SB1400-0A 1SCHLIEßER + 1ÖFFNER	SIEMENS
RSS126	SW-00280356	turning lever 3SB1000-3AB01 0-I VERRASTEND	SIEMENS
RSS126	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS142	SW-00280356	turning lever 3SB1000-3AB01 0-I VERRASTEND	SIEMENS
RSS142	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS171	SW-00280356	turning lever 3SB1000-3AB01 0-I VERRASTEND	SIEMENS
RSS171	SO-00280372	control element 3SB1320-0A SOCKEL MIT 1 SCHLIEßER/1ÖFFNER	SIEMENS
RSS198	SA-00401196	off-switch 5 TE 3111 zum Aufschnappen auf Hutschiene	SIEMENS
RSS208	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS208	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS208	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS208	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
RSS208	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS

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denomination : BBS 560/1060@220/440V,60Hz "e067"
name : HÖROLD
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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
RSS210	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS210	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS210	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS210	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
RSS210	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
RSS212	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS212	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS212	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS212	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
RSS212	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
RSS214	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS214	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS214	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS214	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
RSS214	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
RSS222	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS222	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
RSS222	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS222	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
RSS222	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
RSS224	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS224	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS224	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS224	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
RSS224	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
RSS226	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS226	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS226	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS226	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS
RSS226	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
RSS228	SW-00280364	turning lever 3SB1000-3EB01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
RSS228	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
RSS228	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
RSS228	SZ-00268356	control element 3SB1400-0C 1ÖFFNER	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
RSS228	SZ-00268372	press piece for drive unit 3SB1912-0AN	SIEMENS
*RSS252	SW-01396439	turning lever with luminous reg. 3SB1001 - 8SQ01 I-0-II TASTEND MIT RÜCKSTELLUNG	SIEMENS
*RSS252	SO-00268313	control element 3SB1300-0B SOCKEL MIT 1 SCHLIEßER	SIEMENS
*RSS252	SZ-00268348	control element 3SB1400-0B 1SCHLIEßER	SIEMENS
*RSS252	HI-01396471	glow lamp 3SB1902-2AB mit BI-PIN-ANSCHLUSS	SIEMENS
SC139	DN-00342238	speed indicator AA 9050 110V, 50/60Hz, 10-100 lpm	DOLD
SV126	YM-00089133	magnet valve Ø 1,5 mm 121 F04 110V,60Hz/8W	LUCIFER
SV127	YM-00651338	magnet valve -4/3 dir.seat valve 4WE6 G5X/AW110-60N Z4 110V,60HZ	REXROTH
SV128	YM-00651338	magnet valve -4/3 dir.seat valve 4WE6 G5X/AW110-60N Z4 110V,60HZ	REXROTH
SV130	YM-00089133	magnet valve Ø 1,5 mm 121 F04 110V,60Hz/8W	LUCIFER
SV208	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV209	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV210	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV211	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV212	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV213	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
SV214	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV215	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV222	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV223	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV224	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV225	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV226	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV227	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV228	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
SV229	YM-00652695	magnet valve - direct.seat valve 4WE6 E50/AW110-50N Z4 110VAC	REXROTH
T62	TS-00433284	transformator IST 400VA prim. 575V, 440V, 220V ±5% sec.1: 110V/80V, sec.2: 27V/24V,	ISMET
TCS149	FT-00356603	switch cabinet thermostat SK 31 10-11 +15C°- +45C°	RITTAL
TR62	KT-00310794	time relay 0,15-3sec MK 9903.81 1W 110V 50/60HZ	DOLD
TR86	KT-00097535	time relay 0,5-10sec MK 9903.81 1W 110V 50/60HZ	DOLD
TR107	KT-00412139	time relay 5-100sec MK 9903.81 1W 110V 50/60HZ	DOLD
	KR-00280127	relay base RPZ 112 24V DC	MURR ELEKTRONIK
	VR-00697486	varistor-modul PRV 250 110-250V AC/DC, für Typ PH,PD,PE	SIEMENS

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device	piece-No.	denomination technical description 1.line technical description 2.line	manufacturer
	VR-00697486	varistor-modul PRV 250 110-250V AC/DC, für Typ PH,PD,PE	SIEMENS
	VV-00339768	valve erasing link VBS-RC 022/220L 24063 220V	MURR ELEKTRONIK
SCHALTSCHR	ZS-00338346	control panel AP 2670 1000X960X400/480mm GRUNDIERT	RITTAL
ZULEITUNG	ZG-00383856	connection box K12-20/15 120 * 200 * 150 mm	HÄWA
OBERTEIL	ZG-00247766	connection box K8-25/15 80 * 250 * 150 mm	HÄWA
*Magnete	ZS-00346780	switch cabinet AE1038 HBT 600x380x210	RITTAL
Bedientafe	ZB-01438239	ALU-control panel for BBS	KASTO
ALU-Schild	ZB-01323563	ALU-board for BBS 560/1060	KASTO
*	ZG-00364509	movable controle panel TS 2	GESSMANN
VORSCHUB	ZG-00363863	connection box CT-581 Nr. 258000 120 * 80 * 55 mm	BERNSTEIN
STÄNDER	ZG-01318438	connection box K12-50/20 500 * 200 * 120 mm	HÄWA
*AGGREGAT	ZG-00377015	connection box 80 * 120 * 50 mm	BERNSTEIN
*AGGREGAT	ZG-00335282	connection box K12-40/15 400 * 150 * 120 mm	HÄWA
*MESSANSCH	ZG-00247766	connection box K8-25/15 80 * 250 * 150 mm	HÄWA